



**DATA SHEET**  
**DS 172**  
**Rev. 04 dd 10/03/09**  
**INETUB MHF 600**

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**CLASSIFICATION**

AWS SPECIFICATIONS	EN SPECIFICATIONS
	EN 14700: T Fe8
	(DIN 8555: MSG6-4Z-60)

**APPROVALS**


**ALLOY TYPE**

Flux-cored wire for hard-facing.

**APPLICATIONS**

Metal-cored wire mostly used with semiautomatic and automatic procedures, for hard-facing wheels, rolling mill rollers tracks, sliding rollers, screws, mil crushing jaws and mill wheels, where excellent resistance to abrasion is required especially when accompanied by shocks, and blows, and for hard-facing wearing components such as excavation buckets and teeth and surfaces subject to abrasion and heavy loads. Excellent wetting of the weld metal, very good weld quality, good-looking weld bead and rather limited spattering. To be used under the shield of Ar+CO<sub>2</sub>.

**MATERIALS TO BE WELDED**

ASTM		EN		Others
		(BS 4360)		
		(BS 3100)		
		(BS 1504)		

**WELDING GUIDELINES**

Machinability by grinding wheel and possible quenching at 880°C oil, annealing at 850°C.

**TECHNICAL INFORMATION**

Gas: CO<sub>2</sub> & Mix Ar- CO<sub>2</sub> (EN ISO 14175)  
 Welding positions: flat and flat-frontal



**WELDING PARAMETERS**

Current	DC + Reverse polarity					
	1.0	1.2	1.4	1.6		
Diameter (mm)	1.0	1.2	1.4	1.6		
Volts (V)	18 ÷ 27	19 ÷ 30	20 ÷ 32	22 ÷ 34		
Intensity (A)	110 ÷ 230	120 ÷ 270	130 ÷ 300	140 ÷ 330		



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**TYPICAL CHEMICAL COMPOSITION OF WELD METAL**

GAS	C %	Mn %	Si %	S %	P %	Cr %	Ni %	Mo %	Cu %
M21	0.45	1.30	0.60	0.012	0.012	5.00	-	0.65	-

**TYPICAL MECHANICAL PROPERTIES**

GAS		Hardness
		(HRc)
M21	as welded	~ 58

**PRODUCTS AVAILABLE**

Process	Product	Classification AWS	Classification EN
MIG/MAG Solid wire	INEFIL 600 BR		EN 14700: S Fe8
TIG Rods	INETIG 600 BR		EN 14700: S Fe8
SAW Submerged arc			
FCAW Cored wire			
SMAW Electrodes	INE RD 600		EN 14700: E Fe4