

ED-A 35		
Classification DIN EN ISO		Classification AWS
14700 S Fe2		-
Approvals		Material No.
-		1.8405
Characteristics and application		
MIG/GMAW wire for hardfacing applications. The wire is used for applications requiring excellent impact resistance, or as a buffer layer prior to higher hardness deposits (eg. ED-A 60). The weld deposit has a nominal hardness of 350HB and can be machined using most standard milling, turning and cutting techniques.		
Hardness		
325-375 HB		
Base materials		
For hardfacing and build-up applications on a wide range of mild steels, low alloy steels, engineering and construction steels.		
Typical analysis in %		
C	Mn	Cr
0,7	2,00	1,00
Typical heat treatment		
Weld procedure requirements dependent on material being surfaced.		