

ED-A 65					
Classification DIN EN ISO			Classification AWS		
14700 S Fe3			-		
Approvals			Material No.		
-			1.2606		
Characteristics and application					
MIG/GMAW wire for hardfacing applications. The wire is predominantly used for applications requiring good abrasion resistance up to 500°C such as mixers, crushers and earth moving equipment but deposits will withstand high impact. With final deposit hardness being nominally 60HRC the weld metal can only be ground. If very thick build-ups are required it is suggested that lower hardness wires (eg. ED-A 35) be used as a buffer layer.					
Hardness					
55 - 60 HRC					
Base materials					
For hardfacing applications on a wide range of mild steels, low alloy steels, engineering steels, construction steels and wear resisting steels.					
Typical analysis in %					
C	Si	Mn	Cr	Mo	V
0,35	1,10	0,40	5,50	1,20	0,25
Typical heat treatment					
Weld procedure requirements dependent on material being surfaced.					