



746

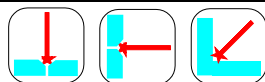
EN 14700 T Fe8

DESCRIPTION

Meltolit 746 is a seamless copper coated tubular wire for semi-automatic gas shielded hardfacing. Strong and tough hot working steel type deposit for service temperatures up to 550°C. No moist pick up and perfect feeding properties. Designed to weld horizontal, horizontal-vertical and vertical-up positions with pulsed or short-circuiting mode of transfer.

Applications: Hardfacing parts undergoing metal to metal wear, compression and moderate impact loads at high temperatures. Hot shear blades, hot and cold punching tools, extrusion press pistons, forging and trimming tools etc.

WELDING POSITIONS



CURRENT TYPE

DC(+)

GAS

M12, M21, M13

MECHANICAL PROPERTIES

Hardness

As welded 44HRC, After PWHT 550°C/10 hours 47HRC

TYPICAL CHEMICAL COMPOSITION(%)

C	Si	Mn	Cr	Mo	Ti	Fe	
0,2	0,5	0,9	6,0	3,5	0,25	Rest	

PACKING INFORMATION AND WELDING PARAMETERS

Dimension(mm)	1,2	1,6
Spool(kg)	15	15
Stick-out(mm)	12-18	12-18
Amperage(A)	110-300	130-350
Voltage(V)	16-32	16-32
Gas flow (l/min)	10-20	10-20

EQUIVALENT CONSUMABLES

MMA	Meltolit 7140 E
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