

GRIDUR F-49W(HH)

TOP FEATURES

- Gas shielded cored wire for regeneration and hardfacing with hardness of 54 HRC and PWHT applications.
- Applicable for stress relieving at 580°C
- 54 HRC
- Cr-Mo-W-V alloying system

TYPICAL APPLICATIONS

- Maintenance and Repair

CLASSIFICATION

EN 14700 T Fe8

CURRENT TYPE

DC+

WELDING POSITIONS

Flat/Horizontal

SHIELDING GASES (ACC. EN ISO 14175)

M21 Mixed gas Ar+ (>15-25%) CO₂
Flow rate 15-25 l/min

CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, ALL WELD METAL

C	Mn	P	S	Si	Cr	Ni	Mo	V	Ti	W
0.38	0.7	0.015	0.015	0.6	5.7	0.3	2.9	0.8	0.15	2.9

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition*	Hardness
Typical values	AW	54 HRC
	SR 10h/580°C	54 HRC

* AW = As welded; SR = Stress relieved

PACKAGING AND AVAILABLE SIZES

Wire diameter (mm)	Packaging	Weight (kg)	Item number
2.0	SPOOL	20.0	81241520

TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application

Safety Data Sheets (SDS) are available here:



Subject to Change – The information is accurate to the best of our knowledge at the time of printing. Please refer to www.lincolnelectric.eu for any updated information.