

AX-650
AX-2606

Material no.: 1.2606

Standards

DIN EN 14700:	S Fe3
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Properties

AX-650 is used for highly wear-resistant deposit welds on components exposed to severe abrasion as well as impact and shock stress. Suitable for temperatures up to 500°C. The weld metal is machinable by grinding.

Important base materials / Important applications

Application e.g. for hammer drills and chisels, shredder hammers, cutting tools and also suitable for use as reinforcement on work surfaces and cutting edges of hot and cold forming tools etc.

Typical composition of welding rod / solid wire in %

C	Si	Mn	Cr	Mo	V	W
0.35	1.1	0.4	5.5	1.2	0.25	1.3

The chemical composition of the pure weld metal depends on the welding parameters applied.

Mechanical properties of all-weld metal (typical values)

Hardness	[HRc]	55 – 60
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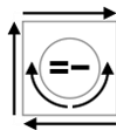
Shielding gas: 100% Argon, PWHT: untreated

The hardness of the weld metal depends strongly on the degree of mixing with the base metal and its chemical composition. These influencing factors decrease with the number of layers.

Operating data

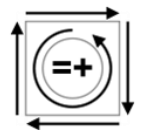
TIG:

Shielding gas: I1 (100%Argon)
acc. to ISO 14175



GMAW:

- M1
- M2
- M3
- C1



Welding area to be ground. Preheat to 150°C - 300°C only for solid components. With more than 3 layers buffer/build-up layer to be welded with AX-250.

Packaging and available sizes

Spools	Ø mm	1.0	1.2	1.6			
Rods	Ø mm x 1000mm	1.0	1.2	1.6	2.0	2.4	

Other dimensions on request.