

## QuFe60

(W.-Nr. 1.3348)

is used for surface and repair welding on new parts and repairs to cutting tools, eg. drills, milling tools, reamers, lathe chisels and other cutting tools. Furthermore suitable for hard facing, tools parts and edges vulnerable to wear. Pre-heating is recommended, the first layer is free from cracks even on critical steels.

### Recommended for:

High speed steel – Cutting steels – PM Steels  
Specially suitable for 1.3316, 1.3333, 1.3344, 1.3346

### Rework

material-typical treatment

### Material analysis in %

C	Si	Mn	Cr	Mo	W	V	Fe
0,97- 1,07	0,45	0,4	4,5	8,0- 9,20	1,5- 2,0	1,80- 2,20	Rest

(test certificates upon request.)

### Standard/Mechanical Values

Ø	N / mm <sup>2</sup>	elongation AL100	Items on stock	
			rods	spools
0,2	-	-	-	-
0,3	-	-	X	X
0,4	-	-	X	X
0,5	-	-	X	-
0,6	-	-	X	X
0,7	-	-	X	-
0,8	-	-	-	-

### Hardness after welding

Ø	HRC	base material
1. layer		
2. layer		
3. layer		

(results on request)

### Following standard:

#### Laser welding wires

rods: 333 mm / 1.000 mm

spool: K80 / K125 / K250 / SH253 / MA125

(The reported values were determined by the manufacturer and / or by a neutral Laboratory determined. For the accuracy we can not guarantee)