



DATA SHEET
DS 066
Rev. 04 dd 10/03/09
INEFIL 350

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CLASSIFICATION

AWS SPECIFICATIONS	EN SPECIFICATIONS
	EN 14700: S Fe2

APPROVALS

ALLOY TYPE

Copper-coated solid wire for hard-facing.

APPLICATIONS

Copper-coated solid wire for hard-facing suitable to restore surfaces to be subjected to abrasive wear. 350 Brinell is obtained in all weld metal conditions and it depends on material type and the number of deposited layers. A cushion layer deposited with basic-coated electrode or basic flux cored wire is essential only with hard-to-weld steels. To be used under the shield of Ar+CO₂.

MATERIALS TO BE WELDED

ASTM	EN	Others
	(BS 4360)	
	(BS 3100)	
	(BS 1504)	
	(BS 11)	

WELDING GUIDELINES

Machinability by grinding wheel and possible quenching at 880°C oil, annealing at 850°C.

TECHNICAL INFORMATION

Gas: Mix Ar- CO₂ (EN ISO 14175)
 Welding positions: all positions



WELDING PARAMETERS

Current	DC + Reverse polarity				
Diameter (mm)	0.8	1.0	1.2	1.6	
Volts (V)	16 ÷ 28	17 ÷ 32	18 ÷ 34	19 ÷ 38	
Intensity (A)	60 ÷ 200	80 ÷ 260	100 ÷ 360	130 ÷ 450	



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TYPICAL CHEMICAL COMPOSITION OF WIRE

C %	Mn %	Si %	S %	P %	Cr %	Ni %	Mo %	Cu %	
0.07	0.50	0.40	0.010	0.010	5.80	-	0.60	-	

TYPICAL MECHANICAL PROPERTIES

GAS	Hardness
	(HB)
MIX	~ 350

PRODUCTS AVAILABLE

Process	Product	Classification AWS	Classification EN
MIG/MAG Solid wire			
TIG Rods			
SAW Submerged arc			
FCAW Cored wire	INETUB MHF 450		EN 14700: T Fe2
SMAW Electrodes	INE RDB 450		