



# HF600

Hardfacing WIRE/GTAW



## Standards

**EN/ISO-Standard** - 14700

**EN/ISO-Classification** - S Fe 8

**DIN-Standard** - 8555

**DIN-Classification** - MSG 6-GZ-60-GP

## Features and Applications

- Copper coated high alloy solid wire for hardfacing and overlay of all C-Mn steels.
- This alloy deposits a martensitic structured weld metal with a hardness of about 54-60 HRC.
- Excellent abrasion resistance to moderate impact and high toughness.
- The weld metal has a Cr-Si structure and if not tempered can only be machined by grinding.
- Mostly used with semiautomatic and automatic procedures.
- A buffer layer is essential with hard to weld steels.
- Precision layer wound for superior wire feeding characteristics.
- Typically used on excavators in the mining industry, cylinder crushers, pneumatic hammers, knives, cutting and cold working tools, crumbling jaws, anvils, caterpillars, screws, guide rollers, etc.
- **Test Certificates can be found online @wilkinsonstar247.com**



## Typical Base Materials

X45CrSi9-3, 4Xr9Si2, X45CrSi8, HNV1, HNV2, SUH11, X45CrSi 9-3, 401 S45, SUH 1, STR 1, 40Ch9S2\*

\* Illustrative, not exhaustive list

## Shielding Gases

EN ISO 14175 - TIG: I1 (Argon)

## Polarity

DC (-)

## Chemical Composition % (Typical)

C %	Mn %	Si %	S %	Cu % <sup>a</sup>	P %	Ni %	Cr %
0.46	<0.60	3.05	<0.030	<0.25	<0.040	<0.50	9.10

<sup>a</sup> (Includes copper coating)

## Packaging Data

Part No.	Diameter Ø (mm)	Package Length (mm)	Package Weight (Kg)	Package Type
<b>6031100487</b>	1.60	1000	1	Cardboard Tube
<b>6031100320</b>	2.40	1000	1	Cardboard Tube

Drums also available.

## Mechanical Properties

### Hardness (HRC)

54 - 60

Mechanical properties are approximate and may vary based on the heat, shielding gas, welding parameters and other factors.