

# Dual Core HF 55-O

Hardfacing **CORED/MCAW**

## Standards

EN/ISO-Standard - 14700

EN/ISO-Classification - T Fe15

## Features and Applications

- Metal cored tubular wire for self-shielded metal arc hardfacing.
- High chromium cast iron deposit containing a high proportion of hard primary chromium carbides in a tough austenitic matrix.
- The deposit is suitable for hardfacing components subject to extremely severe abrasive wear and moderate impact.
- Relief checking is normal and does not affect the properties of the deposit. However it is recommended putting down only two layers unless impact loading is small.
- Multi-layer deposits are possible in specific applications.
- Precision layer wound for superior wire feeding characteristics.
- Typically used on gyratory crusher cones and mantles, catalyst pipes and valves, slurry pipes and valve bodies, dredge pump bodies, sand dredge parts, extruder screws, "bar-mac" crushers, mining and earthmoving equipment, blast furnace bells, brick muller tyres, crusher hammers and rolls, riddle plates, wear plates, drag line components, screw conveyors for cement, cone knives and shredders, etc
- **Test Certificates can be found online @wilkinsonstar247.com**



Optional  
Plastic Alignment Hole Clip  
Order Code: BS300-CLIP

## Welding Positions

EN ISO 6947 - PA

## Welding Parameters

Ø mm	1.20	1.60
Current (A)	100-250	160-320
Voltage (V)	21-28	24-30

## Hardness (HRC)

Current Type	Hardness - Third Layer
DC+	58-64

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

## Wear Type Suitability

Abrasion	<div style="width: 100%;"></div>
Impact	<div style="width: 75%;"></div>
Metal-Metal	<div style="width: 25%;"></div>
Corrosion	<div style="width: 10%;"></div>
Temperature	<div style="width: 80%;"></div>

## Chemical Composition % (Typical)

C %	Mn %	Si %	P %	S %	Cr %	Ni %	Mo %	Fe %	Nb %
5.5	1.2	1.7	0.008	0.010	28.0	0.15	0.04	Bal	0.020

## Packaging Data

Part No.	Diameter Ø (mm)	Package Weight (Kg)	Package Type	Pallet Quantity
6011100361	1.20	15	BS300 PLW	72
6011100365	1.60	15	BS300 PLW	72

**Liability:** Whilst all reasonable efforts have been made to ensure the accuracy of the information contained, this information is subject to change without notice and can be only considered as suitable for general guidance.

