# **Dual Core HF 600-G**

### **Standards**

EN/ISO-Standard - 14700 EN/ISO-Classification - T Fe2

## **Features and Applications**

- Seamless high fill copper coated tubular wire for semi-automatic applications.
- Ideal for hardfacing components subject to abrasion and moderate impact.
- Unique welder appeal.

Welding Positions

EN ISO 6947 - PA, PB

**Shielding Gases** 

Ømm

Current (A) Voltage (V)

EN ISO 14175 - M12, M20, M21

Welding Parameters

- Deposition rate increased by up to 20% when compared to solid wire.
- Martensitic weld metal contains finely dispersed hard carbides ensuring an optimal balance between abrasion, friction and impact resistance.
- Abrasion resistance at service temperatures up to 450°C.
- Preheat will be determined by the application and whether micro cracking in the deposit is acceptable.
- According to the base material preheating in the range 150°C 300°C may be necessary.
- Precision layer wound for superior wire feeding characteristics.
- Typically used on bucket teeth, bucket lips, bulldozer blades, crusher jaws, scraper blades, chutes, pump housings, conveyor screws, slide plates, gear teeth, crusher hammers, drilling bits, ploughshares, reamers etc.

1.20

110-300

16-32

• Test Certificates can be found online @wilkinsonstar247.com





Optional Plastic Alignment Hole Clip Order Code: BS300-CLIP

#### Hardness (HRC)

Current Type	Hardness - First Layer	Hardness - Third Layer			
DC+	52-55	54-57			
DC -	55-57	57-60			

Peak hardness in the range 50-62 HRC could be achieved in three layers. Direct polarity negative reduces dilution and favours higher hardness.

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

#### **Wear Type Suitability**



#### **Chemical Composition % (Typical)**

1.00

90-250

16-32

<b>C</b> %	<b>Mn</b> %	Si %	<b>P</b> %	<b>S</b> %	<b>Cr</b> %	Ni %	<b>Mo</b> %	<b>Cu</b> %	Fe %	<b>Co</b> %	<b>V</b> %	W %
0.5	1.2	0.6	0.010	0.013	5.7	0.05	0.8	0.10	Bal	0.006	0.010	<0.09

1.60

130-350

16-32

#### **Packaging Data**

Part No.	Diameter Ø (mm)	Package Weight (Kg)	Package Type	Pallet Quantity
6011100264	1.20	15	BS300 PLW	72

Drums also available

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.







Hardfacing CORED/MCAW