

HF600

Hardfacing WIRE/GMAW

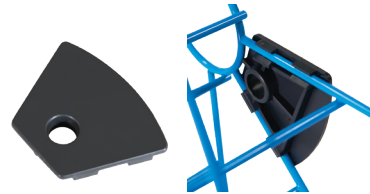
Standards

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**



Optional
Plastic Alignment Hole Clip
Order Code: BS300-CLIP

Typical Base Materials

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

* Illustrative, not exhaustive list

Welding Positions

EN ISO 6947 - PA, PB, PC, PD, PE, PF

Shielding Gases

EN ISO 14175 - M21

Polarity

DC (+)

Mechanical Properties

Hardness (HRC)

54 - 60

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

Chemical Composition % (Typical)

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

a (Includes copper coating)

Packaging Data

Part No.	Diameter Ø (mm)	Package Weight (Kg)	Package Type	Pallet Quantity
6031100317	1.00	15	BS300 PLW	72
6031100318	1.20	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.

