



**PRODUCT INFORMATION**

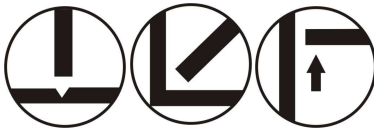
**SIFSTEEL HF6**

Proprietary

**DESCRIPTION**

A Chromium-Molybdenum Steel rod with specific addition of Vanadium, Tungsten and other hardening alloying elements, for the repair and reclamation of machining errors in high-speed steel, tool steels and die steel, and for the hard-surfacing of carbon-steel components.

**WELDING POSITIONS**



Suitable for butt or fillet use in repair and maintenance applications on tool steels, and in providing abrasion-resistance for metal to metal wear on steel components such as wire guides, collars, etc.

**TYPICAL WELD METAL COMPOSITION**

C	1 %
Si	0.5 %
Mn	0.3 %
Cr	4 %
Mo	8 %
V	2 %
W	1.5 %

**TYPICAL MECHANICAL PROPERTIES**

Hardness	~60 HRC
----------	---------

**MATERIAL TO BE WELDED**

Sifsteel HF6 is a unique alloy, making possible the repair welding of die, tool and high-speed steels using the TIG/GTAW process. The reduced heat-affected zone provided by TIG helps to prevent brittling, and the specific addition of vanadium in the Sifsteel HF6 composition provides tool steel compatibility. The weld deposit of Sifsteel HF6 is extremely crack-resistant when repairing difficult-to-weld steels.

**AVAILABLE FORMATS**

1M ROD (TIG / GTAW)			
Dia	12 rod/Pkt	1.0kg Pkt	
1.6mm	ROHF61612	ROHF61601	
2.4mm	ROHF62412	ROHF62401	

Current:	DC =+
Amps:	30-120
Gas	Pure Argon

For further information, contact Weldability | Sif technical support on **0870 330 7757** or email [service@weldability-sif.com](mailto:service@weldability-sif.com)



Doc Ref: SIF/PI/ROHF61612