TECHNICAL DATA SHEET

HF600
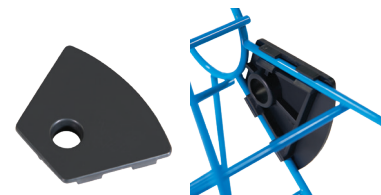
Hardfacing MIG/GMAW

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**

WELD STAR | WIRE

Plastic Alignment Hole Clip
Order Code: 8000000020

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

MAG 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

Made in Switzerland

MIG

WELD STAR