## **TECHNICAL DATA SHEET**

# **HF600**

# Hardfacing MIG/GMAW

#### **Standards**

**EN/ISO-Standard -** 14700 **EN/ISO-Classification -** S Fe 8

DIN-Standard - 8555

 $\textbf{DIN-Classification} \textbf{-} \mathsf{MSG} \textbf{ 6-GZ-60-GP}$ 

### **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





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** 

**Polarity** 

EN ISO 14175 - M21

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)**

<b>C</b> %	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.





