

WELDTECH HARDFACING - WELHF

Specification

AWS Specification: N/A
JIS Specification: DF2B-600-B

Description

- Weldtech HF600 is a lime type electrode, depositing weld metal of a martensite structure.
- Excellent hardness.
- Suitable for soil abrasion and light impact abrasion.

Application

- Hard facing of bulldozer blades, tractor parts, reamer bits, twists, drills, and taps.

Remarks

- Preheat at 150°C and over.
- In the case of multi-layer build-up welding or hardenable steel welding, underlay with low hydrogen type electrode (E7016 or E8016).
- Dry the electrodes at 300-350°C for 30-60 minutes before use.

Technical Data

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL DEPOSITS (%):

C	Si	Mn	Cr	Mo	V
0.76	0.87	0.40	7.45	0.52	0.57

HARDNESS OF WELD METAL:

Hardness	Vickers (Hv)	Rockwell (H _R C)
Value	580 - 630	54 - 57

SIZE AND RECOMMENDED CURRENT RANGE: AC, DC (+)

ORDER CODE	WELHF-32
DIAMETER x LENGTH (mm)	3.2 x 350
Current Amp	90 - 130

Welding Positions: FLAT, HORIZONTAL, OVERHEAD