

# HF600

Hardfacing WIRE/GMAW

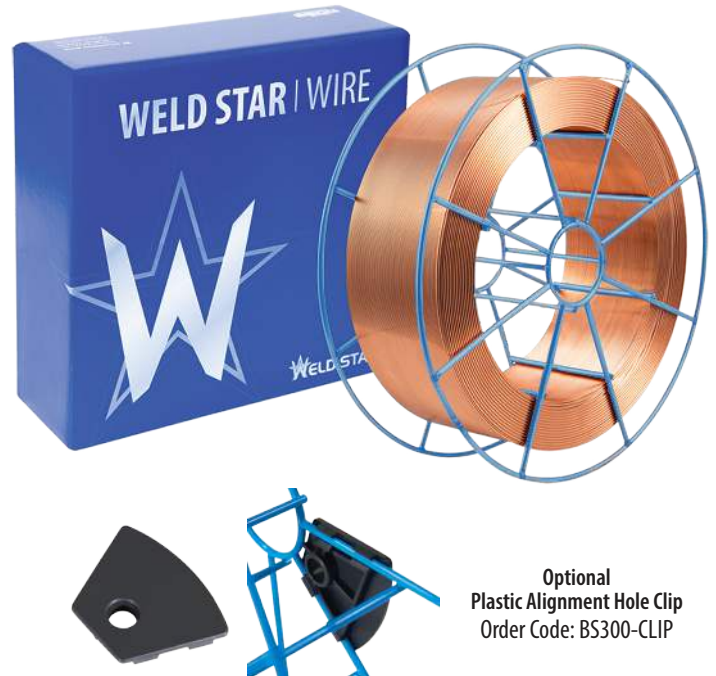
## Standards

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 % <sup>a</sup> | 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.

