

HF600

MIG/GMAW hardfacing wire

Product name	HF600
Classification EN ISO	14700: SFe8.
Material No.	1.4718
Classification AWS	AWS A5.21: ~ERFe3
Approvals	-
Applications	MIG/GMAW wire for hardfacing applications. The wire is predominantly used for applications requiring good abrasion resistance such as mixers, crushers and earth moving equipment but deposits will withstand moderate impact. With final deposit hardness being nominally 60HRC (650HV) the weld metal can only be ground. If very thick build-ups are required it is suggested that lower hardness wires (eg. HF350) be used as a buffer layer.
Base materials	For hardfacing applications on a wide range of mild steels, low alloy steels, engineering steels, construction steels and wear resisting steels.
Typical analysis of wire, weight %	C: 0.45 Si: 3.00 Mn: 0.40 Cr: 9.30
Typical heat treatment ⁽¹⁾	Welding procedure will be primarily dependent on the base material being hardfaced. Typically the weld deposit will be left in the as-welded condition and for most applications there will be no need for preheat; although thick or complex sections may benefit from preheating.
Mechanical properties of weld deposit ⁽²⁾	Hardness: 595-700HV 560-650HB 55-60HRC
Other products	-

Notes (1) Application codes and project specifications should always be referred to for specific requirements.

(2) Actual mechanical properties will be dependent on specific welding procedure (including shielding gas, flux, PWHT etc) and should always be confirmed by approval of an appropriate welding procedure.