

ULTRA HARD FACING 600

FLUX CORED WIRE

Hardfacing Wire for Extreme Abrasion
Resistance

CLASSIFICATION:

- Hardfacing Wire
- Self Shielded / Gas Shielded
- Deposit Hardness: ~ 58 – 63 HRC
- Recommended for single layer build-up

TYPICAL APPLICATIONS:

- Chutes & hoppers
- Sinter plant parts
- Coal mining tools
- Cement kiln components
- Fan blades, Screw conveyors

KEY FEATURES:

- Exceptional resistance to extreme abrasion
- Non-machinable surface
- High chromium carbide alloy
- Smooth arc with good bead appearance • Ideal for single layer hardfacing

TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL WT (%):

C – 5.2	Mn – 0.5	Si – 1.0	Cr – 32.0	Fe – Bal	
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MECHANICAL PROPERTIES OF WELD METAL:

Hardness (HRC)	Impact Resistance	Abrasion Resistance
58–63	Low	Very High

PARAMETERS & PACKING DATA:

Ø x L mm	Amperage, A
1.2	160-280
1.6	220-360

DCEP(Electrode Positive)

Do not apply multiple layers.

Use 1–2 volts lower when using mix shielding gas.

Available in 15 kg vacuum pack wound on plastic spool.



DCEP

Electrode Positive

All positions except vertical down



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mix shielding gas