

# HD-60

SEAMLESS COPPER-COATED CORED WIRES FOR HARDFACING



EN ISO 14700 : T Fe8

APPROVALS: /

## FEATURES:

- . Seamless copper coated tubular wire for gas shielded hardfacing
- . Unique welder appeal
- . Excellent current transfer
- . Very good feeding performance
- . Welding in horizontal, horizontal-vertical and vertical-up position
- . Excellent weldability and high productivity

## APPLICATIONS

- . Bucket teeth
- . Bulldozer blades,
- . Crusher hammers
- . Dies
- . Ploughshares
- . Crusher jaws

## WIRE TYPE

Gas shielded metal-cored wire for semi-automatic gas shielded hardfacing

## SHIELDING GAS

80% Ar + 20% CO<sub>2</sub>, Gas flow 15-25 l/min

## POLARITY

DC+

## WELDING POSITIONS

All Position

## TYPICAL DIFFUSIBLE HYDROGEN

<3.0 ml / 100g; Guaranteed for the total processing time < 4.0 ml / 100 g

## STANDARD DIAMETERS

1.2mm

## RE-DRYING

Not required due to seamless wire design

## STORAGE

Stored in a dry, enclosed environment, in its original undamaged packaging

## PACKAGING

5kg Plastic spool, 15kg Wire basket spool B300

## DEPOSITED METAL ANALYSIS (WT%, TYPICAL)

Carbon ( C )	0.576	Chromium (Cr)	8.970	V	0.007
Silicon (Si)	2.750	Nickel (Ni)	0.021	Ti	0.030
Manganese (Mn)	0.701	Nb	0.020	Mo	0.070

## MECHANICAL PROPERTY

Hardness as welded, 3-layer deposit on alloyed tool steel: 57-62 HRC

## TYPICAL OPERATING PROCEDURE

Diameter (mm)	Volt (V)	Ampere (A)	Electrode Stick-out (mm)	Gas Flow (L/min)
1.2	16-32	110-300	15-20	15-25

According to the base material preheating in the range 150°C - 300°C may be necessary.

**XinXiang HeGuang Technology Co., Ltd.**