

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% CO2, 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.

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