

HD-60M

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 rutile flux-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)

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Carbon (C)	0.300	Chromium (Cr)	4.500	V	0.007
Silicon (Si)	0.400	Nickel (Ni)	0.300	Ti	0.030
Manganese (Mn)	2.200	Nb	0.020		

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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