

Introduction

HFK 130-G is a CO₂ gas-shielded and low alloyed flux cored wire for buildup or use as a final layer. The deposit is tough, machinable, and proper for components subject to metal-to-metal wear.

Abrasion	
Impact	
Metal to Metal	

Typical applications

Buffer layers on ferritic steels before hardfacing, build-up, gear teeth, conveyor chains, rolls, shafts, bearing tracks, idlers, and mine car wheels.

Chemical composition of deposited metal* (%)

C	Cr	Mn	Mo	Si	Fe
<0.2	<2.0	0.5-1.5	<1.0	<1.0	Balance

*Depending on the properties of the base metal, the chemical composition may be different.

Mechanical properties

Layers	Hardness (HB)
3-Layer deposit	250-300

Recommended welding parameters

Diameter: in (mm)	Current (A)	Voltage (V)
1/16 (1.6)	200-280	22-28

Diameters and packaging

Diameter: in (mm)	Packaging: lb (kg)
1/16 (1.6)	33 (15) - Spool