

Introduction

HFK 150-G welding wire is a CO₂ gas-shielded flux cored wire that produces some slag. Its welding performance is excellent without much spatter, the wire's arc is stable, slag removal is easy, and the welding beads have a beautiful appearance.

| | |
|----------|--|
| Abrasion | |
| Impact | |
| Heat | |

Typical Applications

The welding wire is suitable for high-precision surfacing, repair of mechanical parts, and cold-rolled backup rolls.

Chemical composition of deposited metal (%)

| C | Cr | Ni | Mn | Mo | V | Si | Fe |
|-----|-----|-----|-----|-----|-----|-----|---------|
| 0.4 | 5.5 | 0.5 | 1.3 | 1.0 | 0.5 | 1.0 | Balance |

Mechanical Properties

| Layers | Hardness (HRC) |
|--------------|----------------|
| Second Layer | 50-52 |

Recommended welding parameters

| Diameter: in (mm) | Current (A) | Voltage (V) |
|-------------------|-------------|-------------|
| 0.045 (1.2) | 160–220 | 22–25 |
| 1/16 (1.6) | 200–280 | 22–28 |

DC reverse connection

| Shielding Gas | Gas Flow: cfh (l/min) | Torch angle | Stick Out: in (mm) |
|----------------------|-----------------------|-------------|--------------------|
| 100% CO ₂ | 40 (20) | 80° | 1/2–3/4 (15–20) |

Diameters (mm) and Packaging

| Diameter: in (mm) | Packaging: lb (kg) |
|-------------------|--------------------|
| 0.045 (1.2) | 33 (15) |
| 1/16 (1.6) | 33 (15) |