


Introduction

HFK 600-O is a high-chromium cast iron surfacing welding wire. It is suitable for welding surfaces that require strong wear resistance.

Abrasion	
Impact	
Corrosion	
Heat	

The appearance of the welded surface is beautiful, and welding this wire produces no slag. Though shielding gas is not mandatory, CO₂ should be used for best results.

Typical applications

Used for surfacing in situations which normal and medium temperature abrasion and corrosion resistance are needed. Application examples include fan blades, augers, mixer components for parts attacked by corrosion, conveyors and screws, dredge parts, cement pulverizer rolls, clinker grinding rolls, and wear plates.

Chemical composition of deposited metal (%)

C	Cr
2.50–4.50	17.0–28.0

Mechanical properties

Layers	Hardness (HRC)
Second Layer	55–62

Recommended welding parameters

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

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 and packaging

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