

CLASSIFICATIONS

EN 14700 : T Fe1
DIN 8555 : MF 1-GF-300 P

DESCRIPTION

- Suitable for uses in buffer-layer welding before hardfacing applications on parts exposed to high impact/pressure/wear. Alloy group is low alloy steel. Low alloy wire designed for build-up on carbon steels. Slag removal is very good. WI HFCORE 300 O has excellent compressive strength and resistance to cracking. Machinability is very good. Requirement of cleaning of base material's surface and of heating of the base material at approximately 150°C. Build up is generally unlimited with proper heat treatment procedures. Shielding Gas: Open Arc

CHEMICAL ANALYSIS OF WELD METAL % (TYPICAL)

C: 0.13 | Si: 0.30 | Mn: 2.50 | Cr: 1.25 | Fe: Rest

MECHANICAL PROPERTIES

Hardness (as welded)
(HB)

300

BASE MATERIALS

- Steel mill rolls, shafts, steel hammers, gear teeth, shovel pads, conveyor chains, crane wheels, rail track changers, gear wheels, sprockets as well as carrying rollers

WELDING POSITIONS



OPERATING DATA

Diameter (mm)	Welding Current (A)	Voltage (V)	Stick-out (mm)
1.60	180 - 200	26.0 - 30.0	25.0 - 30.0
2.80	300 - 500	23.0 - 31.0	25.0 - 30.0

CURRENT TYPE

FCAW / D.C. (+)

OPERATING DATA

Product Code	Diameter x Length (mm) / (inch)		Package Weight (Kg)
1011100224	1.60	1/16	15
1011100225	2.80	7/64	25