PROWELD HF700 *For Earth and Sand Abrasion*

Classification

DIN 8555 : E 6-UM-60
JIS Z 3251 : DF3C-700-R

Applications

For a wide range of general hard surfacing, such as augers, cultivator blades, agricultural point and ploughshares, ripper teeth and other components subject to fatigue or flexing during service.

Characteristics

PROWELD HF700 is a rutile coated hardfacing electrode which depositing an air hardening martensitic Cr-Mo-V alloy, exhibiting good resistance to all types of abrasion under low to moderate impact conditions, give smooth running with AC and DC, stable arc, low spatter and excellent slag removal.

Typical Chemical Composition of Deposited Metal (%)

C	Si	Mn	Cr	Mo	V
0.70	0.50	0.30	8.0	0.30	0.40

Typical Hardness of Deposited Metal

Vickers (HV)	Rockwell C (HRC)	(As-welded)
560～620	53～56	Single layer onto mild steel*
600～710	55～60	Multiple layer

* Single layer deposit hardness will vary depending on base metal type and degree of dilution.

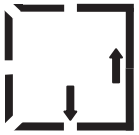
Sizes & Recommended Current Range (AC or DC +)

Diameter/ Length (mm)	3.2/350	4.0/400	5.0/450
Welding Position	Current (A)		
F, V	90～130	140～180	160～240

Guideline in Usage

1. Use dry electrodes only. Damp electrodes should be re-dried at 120～150℃ for 60 minutes before use.
2. Preheat at more than 150℃ is recommended to avoid cracking.
3. A buffer layer with low hydrogen electrode is required to surface hardening metal or to deposit multiple layers.

Welding Positions



Flat butt and vertical up only