

XP HF600

HARDFACING

CLASSIFICATIONS

EN ISO 14700	DIN 8555
S Fe 8	MSG 6-GZ-60

KEY FEATURES AND APPLICATIONS

- High-alloyed solid 600 series wire for hardfacing and overlay of C-Mn steels.
- Provides excellent resistance to abrasion, impact and heat.
- This alloy deposits a martensitic structured weld-metal.
- Depending on the base material, preheating in the range of 300°C to 400°C may be required.
- Commonly used in hardfacing applications within the earthmoving, quarrying and agricultural sectors.

CHEMICAL COMPOSITION OF WIRE %

	C	Mn	Si	S	P	Ni	Cr
MIN	0.40	-	2.70	-	-	-	8.00
MAX	0.50	0.60	3.30	0.030	0.040	0.50	10.00

Single values are maximum values

MECHANICAL PROPERTIES OF ALL-WELD METAL - TYPICAL VALUES

Hardness
≥54 HRC

Test data for mechanical properties are not guaranteed since actual as welded conditions depend on numerous variables

OPERATING DATA

Shielding Gases	Polarity
EN ISO 14175 - I1	DC-

PACKAGING AND AVAILABLE SIZES

Part Number	Diameter (mm)	Length (mm)	Weight (kg)	Packaging
XP20300	1.6	1000	5	PAP 20 Tube
XP20303	2.4	1000	5	PAP 20 Tube
XP20306	3.2	1000	5	PAP 20 Tube