

XP HF650

HARDFACING 

CLASSIFICATIONS

DIN 8555

MSG 3-60

KEY FEATURES AND APPLICATIONS

- High-alloyed solid 650 series wire for repairing hot work tool steels.
- Suitable for operating temperatures up to ~550°C.
- Depending on the base material, preheating in the range of 300°C to 400°C may be required.
- Typical applications include hot shears, continuous casting rolls, die casting moulds, plastic processing screws, forging dies.

CHEMICAL COMPOSITION OF WIRE % - TYPICAL

C	Mn	Si	S	P	Ni	Cr	Mo	W
0.35	0.50	1.00	<0.020	<0.025	<0.20	5.30	1.50	1.30

MECHANICAL PROPERTIES OF ALL-WELD METAL - TYPICAL VALUES

Hardness

≥57 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 - M21	DC+

PACKAGING AND AVAILABLE SIZES

Part Number	Diameter (mm)	Spool	Weight (kg)	Pallet Qty
XP20209	1.2	BS300	15	72