

FLUX CORED WIRE : HARDFACING

SARTHAK HF 550

AWS-A/SFA5.20E71T-1C

Applications

Suitable for surfacing of minerals craine wheels hot & cold punching dies metal cutting & forming tools, crush hammer & catter pillers trades, crane wheels, conveyer buckets. Self tempering deposit for hard facing applications in Mining & Civil Engineering industries.

Characteristics on Usage

A high carbon & high chrome flux core wire depositing a weld metal having excellent resistant of abrasion friction and moderate impact. A deposited weld metal gives Hardness 55 to 60 HRC.

Welding Positions



1G

Recommended Stick Out

20 - 40 mm

Chemical Composition Of Weld Metal

Element	C%	Mn%	Si%	Cr %	V %	Mo %
Spec. Reqd.	0.50-0.80	0.50-1.50	1.0 Max	4.0-8.0	0.75 Max	1.0 Max

Mechanical Properties Of Weld Metal

**HARDNESS
ON III rd
LAYER**

55 – 60 HRC

Welding Parameters (DC + VE)

Diameter (mm)	Flat	
	(A)	(V)
1.20-1.60	200-250	26-32
2.00-2.40	250-350	26-32

Packing

1) 15 kgs.vaccum packed plastic spool for 1.20/1.60mm 2) 10 Kgs.vaccum packed plastic spool for 2.00/2.40 mm.