



MIG HBF17

Old reference:
MIG HBCrMo17-1 / MIG F400C

Classification

EN 14700 : S Z Fe8

N° de Mat. : 1.4122

Description & Applications

Copper coated solid wire for GMAW hardfacing and repairing of alloys like X55CrNiMoV12, X55Cr14, X160CrMoV12. Excellent resistance to corrosion and heat for service temperatures up to 450°C.

Main applications: Hardfacing of gas, water and steam valves as well as cold working tools like stamping tools, cutting edges.

Typical Chemical Composition (%)

	C	Si	Mn	Cr	Ni	Mo	Cu	P	S	Fe
Min										
Max										
Type	0.40	0.50	0.50	16.5	0.50	1.0	0.05	0.02	0.01	Rem.

All Weld Metal Mechanical Properties

Hardness (as welded)
~53 HRC

Welding Current & Instructions

	Ø (mm)	Welding parameters		Shielding gas
		Current (A)	Voltage (V)	
GMAW = +	0.8	100 - 150	22 - 27	ISO 14175: M21 (Ar/CO ₂) 12-15 l/min
	1.0	150 - 190	25 - 28	
	1.2	150 - 220	25 - 28	
	1.6	180 - 270	26 - 32	

Tool steels have to be preheated to 350-450°C, depending on the thickness and composition.

FT En-MR15-210420

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