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 stampoing tools, cutting edges.

Typical Chemical Composition (%)

	C	Si	Mn	Cr	Ni	Mo	Cu	P	S	Fe
Min										
Max	Not specified									
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 1.0 1.2 1.6	100 - 150 150 - 190 150 - 220 180 - 270	22 - 27 25 - 28 25 - 28 26 - 32	ISO 14175: M21 (Ar/CO_2) 12-15 l/min

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