



# TIG HBF17

Old reference:  
TIG HBCrMo17-1 / TIG F400C

## Classification

EN 14700 : S Z Fe8

Material N° : 1.4122

## Description & Applications

Copper coated solid rod for TIG hardfacing 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

Welding mode	Shielding Gas
TIG = -	ISO 14175 : I1 (Ar) 6-12 L/min

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

FT En-TR15-210420

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