



Hardfacing Flux Cored Wire



Code & Specification

Description

BLUME® HF44CrMnNi-OA is a 13% Chromium Nitrogen containing martensitic stainless steel self shielded flux cored wire. The complete martensitic microstructure provides excellent tempering stability, wear resistance, excellent heat resistant fatigue and stress corrosion cracking ability.

Applications

BLUME® HF44CrMnNi-OA is suitable for surfacing continuous casting roller, as well as for surfacing valve seat, gate valve, wedge valve, safety valve, forming roller, pinch roller, etc.

Mechanical Properties

Hard-Surfacing Hardness (HRC) 40 - 48

Undiluted Weld Metal Analysis (wt%)

C	Mn	Si	Cr	Ni
≤ 0.10	≤ 2.0	≤ 1.0	11.5 - 15.0	3.0 - 5.0
Mo	N	Fe		
0.5 - 1.2	0.05 - 0.12	Bal		

Suggested Welding Parameters (DC+)

Diameter	Volts	Amps	Extension Length
2.4mm (3/32")	26 - 35	250 - 400	25mm - 40mm (1" - 1.5")
2.8mm (7/64")	28 - 35	250 - 450	25mm - 45mm (1" - 1.8")
3.2mm (1/8")	30 - 35	300 - 500	30mm - 50mm (1.2" - 2")

Packaging

15 kgs (33 lbs) [Net Weight] Plastic spools with OD = 270mm (11") or 250 kgs (550 lbs) Drum Packing

Notes



Blumenotics Pvt. Limited

An ISO 9001:2015 Company

3rd Floor, No. 23, 5th Cross, Koramangala 5th Block, Bangalore 560 095, India
Tel: +91 80 2528 3432 Email: info@blumenotics.com Web: www.blumenotics.com

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