



Hardfacing Flux Cored Wire



Code & Specification

Description

BLUME® HF44CrMnNi is a 13% Chromium Nitrogen containing martensitic stainless steel submerged arc 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 is often the first choice for surfacing continuous casting roller, as well as for surfacing valve seat, gate valve, wedge 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
3.2mm (1/8")	28 - 32	400 - 500	30mm - 35mm (1.2" - 1.4")

Packaging

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

Notes

