



Hardfacing Flux Cored Wire



Code & Specification

Description

BLUME® HF50MnCr is a common chromium molybdenum type flux cored wire with CO₂ gas protection. The welding arc is stable, the splatter is small, the deslagging is easy and the forming is aesthetic. It is suitable for the workpiece with impact resistance and high wear and tear.

Applications

BLUME® HF50MnCr is suitable for repairing the surface of all kinds of wear parts, such as gears, dredgers, mining machinery, etc.

Mechanical Properties

Hard-Surfacing Hardness (HRC) ≥ 50

Undiluted Weld Metal Analysis (wt%)

C	Mn	Cr
0.30 - 0.60	≤ 4.00	≤ 5.00

Suggested Welding Parameters (DC+)

Diameter

	Amps
1.6mm (1/16")	220-260
2.4mm (3/32")	250-400

Packaging

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

Notes

1. Reverse connection of DC power supply is adopted.
2. During welding, the flow rate of CO₂ gas should be (20-25) l/min.
3. The extension length of welding wire should be controlled with 15mm - 25mm (0.6" - 1").
4. Preheating and interpose temperature are recommended to be around 300°C (572°F).
5. Rust, oil, water and other impurities must be removed before welding.



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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