



Hardfacing Flux Cored Wire



Code & Specification

Description

BLUME® HF62Cr is a high Chromium Cast Iron, which is suitable for low impact and high stress abrasive wear conditions.

Applications

BLUME® HF62Cr is suitable for wear-resistant steel plate, coal mill, cement vertical mill, etc.

Mechanical Properties

Hard-Surfacing Hardness (HRC)	58 - 62
Metallographic Structure	Austenite + Complex Carbide
Machinability	Only Grinding Wheel
Gas Cutting	No
Permission Hard-Surfacing Thickness	As per requirement
Shielding Gas or Soldering Flux	None

Undiluted Weld Metal Analysis (wt%)

C	Mn	Si	Cr	Fe
5.2	1.2	≤ 1.0	28.5	Allowance

Suggested Welding Parameters (DC+)

Diameter	Volts	Amps	Extension Length
2.4mm (3/32")	26 - 30	300 - 370	35mm - 40mm (1.4" - 1.6")
2.8mm (7/64")	26 - 30	300 - 400	35mm - 40mm (1.4" - 1.6")

Packaging

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

Notes

