



# Hardfacing Flux Cored Wire



## Code & Specification

## Description

**BLUME<sup>®</sup> HF65CrNb** is a self shielded flux cored wire, and the deposited metal is Cr-Nb alloy. When the working temperature is less than 450°C, it has good resistance to low impact and high stress solid abrasive wear, and the surfacing metal is easy to release stress cracks.

## Applications

**BLUME<sup>®</sup> HF65CrNb** is suitable for peanut oil press screw, wear-resistant steel plate, sieve plate in coal and steel industry, bucket teeth and pulley of excavator, bucket teeth and blade of mechanical excavator, feed hopper, nozzle, etc.

## Mechanical Properties

Hard-Surfacing Hardness (HRC) 62 - 67

## Undiluted Weld Metal Analysis (wt%)

C	Mn	Si	Cr	Nb
5.50	0.30	-	20.00	7.00

## Suggested Welding Parameters (DC+)

Diameter	Volts	Amps	Extension Length
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

