



Hardfacing Flux Cored Wire



Code & Specification

Description

BLUME® HFCr13 is a Hardfacing wire with subarc flux.

Applications

BLUME® HFCr13 is suitable for continuous casting roll, valve seat, mixer impeller, centrifugal pump impeller and other parts in iron and steel industry, suitable for metal key corrosion and wear occasions.

Mechanical Properties

Hard-Surfacing Hardness (HRC)	45 - 50
Metallographic Structure	Martensite
Machinability	Carbide Tools
Gas Cutting	No
Permission Hard-Surfacing Thickness	As per requirement

Undiluted Weld Metal Analysis (wt%)

C	Mn	Si	Cr
0.3	1.5	0.5	13.5

Suggested Welding Parameters (DC+)

Diameter	Volts	Amps	Extension Length
3.2mm (1/8")	28 - 30	450 - 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



Blumenotics Pvt. Limited

An ISO 9001:2015 Company

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