



# Hardfacing MIG Wire



## Code & Specification

A.I.S.I H13

## Description

**BLUME® HFH13** is for hot work tool steels with excellent hot tensile properties, high hot wear resistance. Heat checking resistance.

## Applications

**BLUME® HFH13** is used in particular to repair mandrels, punches, dies, cylinder crushers, screws, hammers, pneumatic hammers, etc.

## Mechanical Properties

Hardness HRC (As Welded)	54 - 60
Pre Heating Temperature	340 - 370°C (644°F - 698°F)
Current and Polarity	DC+

## Shielding Gas

Argon + CO<sub>2</sub>

## Undiluted Weld Metal Analysis (wt%)

<b>C</b>	<b>Mn</b>	<b>Si</b>	<b>P</b>	<b>Cr</b>
0.40	0.40	1.00	< 0.020	5.20
<b>Mo</b>	<b>Cu</b>	<b>S</b>	<b>Mo</b>	<b>V</b>
1.40	< 0.25	< 0.020	1.40	1.00

## Base Materials to be Welded

X40CrMoV5-1 ; H13, BH 13; SCPH 62, STD 62

## Packaging

1.0mm (.040") Diameter, 1.2mm (.045") Diameter & 1.6mm (1/16") Diameter Wire in 15 kgs (33 lbs) (net) Plastic spools with OD = 270mm (11")

