



# Hardfacing TIG Filler 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

100% Argon

## 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>V</b> |           |
| 1.40      | < 0.25    | < 0.020   | 1.00     |           |

## Base Materials to be Welded

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

## Packaging

1.2mm (.045") Diameter & 1.6mm (1/16") Diameter of 1000mm (40") length in 5 kgs (11 lbs) pack.



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