



Hardfacing TIG Filler Wire



Code & Specification

A.I.S.I M2

Description

BLUME[®] HFM2 is a Tungsten - Molybdenum alloyed welding wire suitable for repairing high speed steels. Excellent toughness and cutting properties for a wide variety of uses.

Applications

BLUME[®] HFM2 is used for twist drills, reamers, broaching tools, metal saws, milling tools of all types, wood working tools, cold working tools, gears, punches, shears etc.

Mechanical Properties

Hardness HRC (As Welded)	60 - 64
Pre Heating Temperature	350°C (662°F)
Current and Polarity	DC-

Shielding Gas

100% Argon

Undiluted Weld Metal Analysis (wt%)

C	Mn	Si	P	Cr
0.90	0.30	0.25	< 0.030	4.2
Mo	Cu	S	Ni	V
5.00	< 0.50	< 0.020	< 0.25	1.80

Base Materials to be Welded

X85WDCV06-04-02 ; V6M05Cr4V2 ; HS 6-5-2 ; M2, J438B ; X85WDCV06-04-02 ; BM2 ; SKH 51 ; R 6 M 5

Packaging

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



Blumenotics Pvt. Limited

An ISO 9001:2015 Company

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