



# Hardfacing TIG Filler Wire



## Code & Specification

A.I.S.I M7

## Description

**BLUME® HFM7** is a molybdenum high speed tool steel solid wire similar to AISI M7 grade. This product characterised by a high hardness (57 to 64 HRC) and excellent wear resistance. It is suitable for use at elevated temperatures.

## Applications

**BLUME® HFM7** is for depositing welding of Mo-alloyed high-speed steel. Maintenance and new manufacture of high-speed steel tools. Weld deposit without soft-annealing can only be processed by grinding. To be used for cutting tools, gouges, turning chisel, broaches, taps, twist drills, reamers, milling tools, cold extrusion dies.

## Mechanical Properties

Hardness HRC (As Welded) 57 - 64

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>
1.00	0.30	0.40	< 0.025	3.80
<b>Mo</b>	<b>Cu</b>	<b>S</b>	<b>W</b>	<b>V</b>
8.60	< 0.50	< 0.025	1.80	1.90

## Base Materials to be Welded

AISI M7 and similar.

## Packaging

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



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