



# Hardfacing Flux Cored Wire



## Code & Specification

## Description

**BLUME® HFMn16** is a CO<sub>2</sub> gas shielded high manganese type flux cored welding wire. The welding wire has the characteristics of working hardening, toughness and wear resistance. The welding arc is stable and easy to deslag.

## Applications

**BLUME® HFMn16** is suitable for single or multi-layer hard surfacing of various crushers, high manganese rails, turnouts, bulldozers and other parts which are subject to impact along with wear and tear.

## Mechanical Properties

Hard-Surfacing Hardness (HB) ≥ 170

## Undiluted Weld Metal Analysis (wt%)

C	Mn	Si
≤ 1.10	11.00 - 16.00	≤ 1.30

## Suggested Welding Parameters (DC+)

### Diameter

Diameter	Amps
1.2mm (.045")	180 - 220
1.6mm (1/16")	220 - 260

## Packaging

15 kgs (33 lbs) [Net Weight] Plastic spools with OD = 270mm (11") or 250 kgs (550 lbs) Drum Packing.

## Notes

- Reverse connection of DC power supply is adopted.
- During welding, the flow rate of CO<sub>2</sub> gas should be (20-25) l/min.
- The extension length of welding wire should be controlled with 15mm - 25mm (0.6" - 1").
- Preheating and interpose temperature are recommended to be around 300°C (572°F).
- Rust, oil, water and other impurities must be removed before welding.

