



Hard-Facing MIG Wire



Code & Specification

A.I.S.I P-20 Mold Steel

Description

BLUME® HFP20 is a medium carbon low alloy steel which contains chromium and molybdenum. The Deposits are that of an AISI P-20 mold steel. The hardness is highly dependent on preheat temperature, length of time welding, and cooling rate. The deposits have similar etching, graining and colour match characteristics as P-20 when tempered to the low 30 HRC range.

Applications

BLUME® HFP20 is used to repair many types of P-20 tools and dies, whether they are die casting dies or plastic injection molds. It is often used for high strength joining of low alloy steels and Chrome Moly Steels.

Shielding Gas

Argon + CO₂

Mechanical Properties

Hardness HRC (As Welded)	34 - 38
Current and Polarity	DC+
Pre Heating Temperature	300°C (572°F)

Undiluted Weld Metal Analysis (wt%)

C	Mn	Si	Mo	Cr
0.35	0.8	0.50	0.40	1.70
P	S	Cu		
< 0.025	< 0.025	0.25		

Packaging

1.2mm (.045”) Diameter & 1.6mm (1/16”) Diameter Wire in 15 kgs (33 lbs) [Net Weight] Plastic spools with OD = 270mm (11”)

