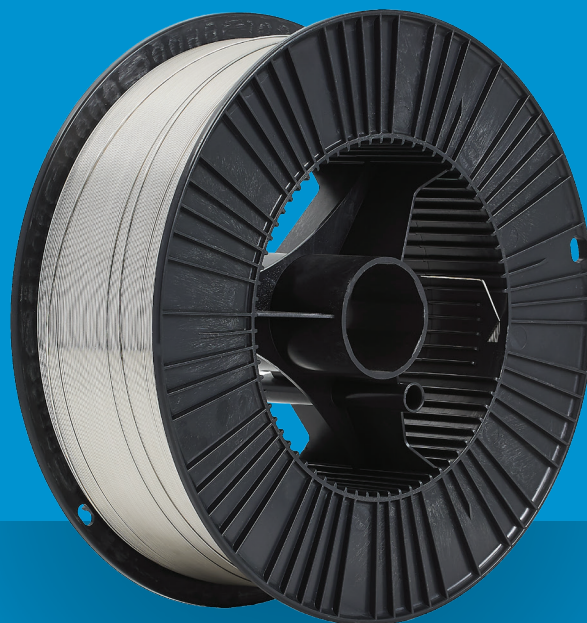


AUTOCRAFT HF650

PRODUCT DATA SHEET



HIGH ALLOYED HARD FACING/SURFACING SOLID WIRE



COBALARC & STODY HARDFACING CONSUMABLES

AUTOCRAFT HF650

- Gas (-G) Shielded All-positional.
- Br hard facing on unalloyed and low alloyed structural steels.
- Resistant to Moderate Particle Abrasion and Moderate Impact Loading.
- Typical applications include the surfacing of agricultural equipment, earth moving equipment, mining sites, dredging, mill rollers, crushers, screws and wheels.

TYPICAL ALL WELD MECHANICAL METAL PROPERTIES:

ARGON + 18-25% CO₂:

Yield Stress	590 MPa
Tensile Strength	2650 MPa

CLASSIFICATIONS:

ISO AS/NZS 2576:	1855-B6
W.T.I.A. Tech Note 4:	1855-B6
DIN 8555:	MSG6-GZ-60-G/P

TYPICAL ALL WELD METAL ANALYSIS:

C:	0.45%
Mn:	0.4%
Si:	3.0%
W:	<0.1%
Cr:	9.3%
Fe:	Balance
Mo:	<0.15%
Cu:	<0.25%
Ni:	<0.15%

DESCRIPTION AND APPLICATIONS:

HF650 is high alloyed hard facing/surfacing solid wire suitable for welding in all positions on unalloyed and low alloyed structural steels that require a wear resistant coating. The specially selected and blended alloying elements of; Carbon Chromium, Molybdenum, Manganese and Nickel and Copper make this product ideal for overlays on metals that are subject to moderate impact and wear, plus metal-to-metal wear and metal-to earth/mineral engaging applications.

Suitable for Gas Metal Arc Welding (GMAW) and Metal Inert Gas (MIG) welding.

HF650 is an ideal choice for out-of-position hard facing/ surfacing jobs as this solid wire out-performs most similar and flux cored wires when it comes to welding on-site.

COMPARABLE CIGWELD PRODUCTS:

Cobalarc 650 extruded electrode
AS/NZS 2576: 1855-A4

TYPICAL ALL WELD DEPOSIT HARDNESS:

	HR _c	HV ₃₀
Single Layer on Mild Steel	55	600
Tensile Strength	60	690

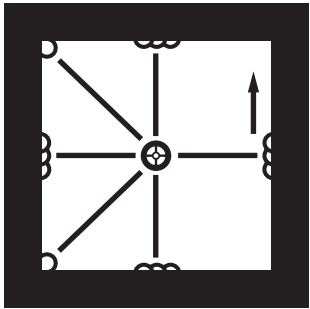
FINISHING RECOMMENDATIONS:

Not Machinable. Grinding only.

RECOMMENDED* SHIELDING GAS:

Ar + 25% CO ₂	
ISO 14175:	M21

WELDING POSITIONS:



PACKAGING & OPERATING DATA:

DC Electrode Negative.

WIRE DIAMETER (MM)	CURRENT RANGE (AMPS)	VOLTAGE RANGE (VOLTS)	ELECTRODE STICKOUT (ESO) MM	PACK TYPE	PACK WEIGHT	PART NO.
0.8	50-80	14-22	10-15	Spool	5kg	720059

