

CIGWELD

AN ESAB BRAND

BLUESTRIKE

BLUESTRIKE HF650

PRODUCT DATA SHEET



BLUESTRIKE ELECTRODE HANDY-PACKS FOR ALL OF YOUR SMALLER PROJECTS

HRC
62

AC
DC

50
OCV

MILD STEEL

BLUESTRIKE HF650:

BlueStrike HF650 is a basic electrode for the hard surfacing of steel components subjected to wet or dry hard particle abrasion and low to moderate impact loading.

The air hardening, low alloy steel deposit of BlueStrike HF650 remains crack free on most steels under normal welding conditions and is therefore recommended for hard surfacing components subject to flexing during service.

The basic flux coating gives excellent resistance to rust, mill scale, dirt and oil on the surface being hardfaced. Typical applications include the surfacing of agricultural points, shares and tynes, grader and dozer blades, conveyor screws and post hole augers etc.

FEATURES:

- Basic Type Manual Arc Welding Electrode
- Air Hardening, Crack Free, Martensitic Steel Deposit - 62 HRC
- Resistant to Hard Particle Abrasion and Moderate Impact Loading

CLASSIFICATIONS:

AS/NZS 2576:	1855-A4
W.T.I.A. Tech Note 4:	1855-A4

SPECIFICATIONS:

Diameter (mm)	Current Range (amps)	
	MIN	MAX
3.2	105	135

TYPICAL WELD DEPOSIT HARDNESS:

	HR _c :
Single Layer on Mild Steel	64
All Weld Metal Deposit	62

TYPICAL ALL WELD METAL ANALYSIS:

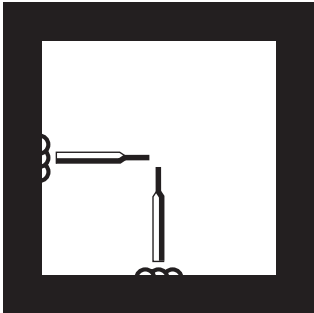
C: 0.58%	Mn: 1.10%	Si: 0.60%
Cr: 5.3%	Mo: 0.25%	

FINISHING RECOMMENDATIONS:

Not Machinable / Grinding only.

WELDING POSITIONS:

Downhand & Horizontal surfacing
Applications: Can be used for vertical
welding by depositing overlapping
horizontal stringer passes



ORDERING INFO:

PART NO.	SIZE PACK	SIZE	CARTON
WEH1032	BlueStrike HF650 Electrodes 3.2mm	1kg	12kg - 12 x 1kg