

CIGWELD

AN ESAB BRAND

WELDSKILL HF650

PRODUCT DATA SHEET



WELDSKILL ELECTRODE HANDY-PACKS FOR ALL OF YOUR SMALLER PROJECTS

HV₃₀
640

AC
DC

50
OCV

MILD STEEL

WELDSKILL HF650:

WELDSKILL 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 WELDSKILL 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 - 650 HV₃₀
- 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 :	HV ₃₀ :
Single Layer on Mild Steel	55	600
All Weld Metal Deposit	57	640

TYPICAL ALL WELD METAL ANALYSIS:

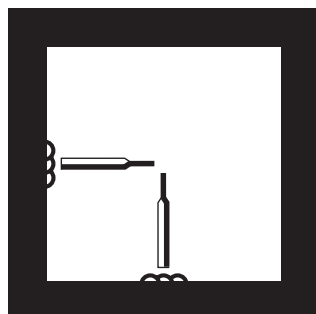
C: 0.58%	Mn: 1.10%	Si: 0.60%
Cr: 5.3%	Mo: 0.25%	

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	WeldSkill HF650 Electrodes 3.2mm	1kg	12kg - 12 x 1kg