

HF350

MIG/GMAW hardfacing wire

Product name	HF350
Classification EN ISO	14700: ~SFe1. 21952-A: ~GCrMo5Si.
Material No.	1.7373
Classification AWS	A5.21: ~ERFe1. A5.28: ~ER80S-B6
Approvals	-
Applications	MIG/GMAW wire for hardfacing applications where significant build-ups are required, possibly prior to finishing with a higher hardness weld deposit (eg. HF600). Also used for surfacing applications where only moderate wear resistance is required, but with good impact resistance. The weld deposit can be machined, or ground, using standard techniques.
Base materials	For hardfacing applications on a wide range of mild steels, low alloy steels, engineering steels, construction steels and wear resisting steels.
Typical analysis of wire, weight %	C: 0.06 Si: 0.70 Mn: 0.90 Cr: 5.70 Mo: 0.75
Typical heat treatment ⁽¹⁾	Welding procedure will be primarily dependent on the base material being hardfaced. Typically the weld deposit will be left in the as-welded condition and for most applications there will be no need for preheat; although thick or complex sections may benefit from preheating.
Mechanical properties of weld deposit ⁽²⁾	Hardness: 350-390HV 330-370HB 36-40HRC
Other products	-

- Notes** (1) Application codes and project specifications should always be referred to for specific requirements.
(2) Actual mechanical properties will be dependent on specific welding procedure (including shielding gas, flux, PWHT etc) and should always be confirmed by approval of an appropriate welding procedure.