

GFC 450HB

HARD FACING FLUX CORED WIRE

IDENTIFICATION

GFC 450 HB

DESCRIPTION

Flux cored wire for hardfacing application by GMAW process.

Deposited weld metals has high resistance against corrosion, abrasion and impact deformation. The wire is universal and finds many applications in the industries.

WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	Cr	Mo
0.22 max	1.60 max	0.50 max	3.25 max	0.40 max

MECHANICAL PROPERTIES (RANGE)

Hardness
450 BHN approx.

TYPICAL APPLICATIONS

Quarries, Mines, Steel works, Cement works industries, Agriculture machinery, Rebuilding of Rolls in steel plants.

MICROSTRUCTURE

Microstructure of the weld metal : Ferrite and martensitic.

PACKING PARAMETERS

Wire Dia (mm)	Welding Parameters		Shielding Gas	Weight / Spool (kg)
	Current DC (+) (Amps)	Voltage (V)		
1.2	150 - 300	23 - 29	80% Ar + 20% CO2 OR 100% CO2	15