

# TALARC HF600

## CLASSIFICATION

AS SPECIFICATIONS	EN SPECIFICATIONS
AS2576: 1855-B6	EN 14700: S Fe8
	(DIN 8555: MSG6-4Z-60)

## ALLOY TYPE

Bronze-coated solid wire for hard-facing.

## APPLICATIONS

Bronze-coated solid wire mostly used with semiautomatic and automatic procedures, for hard-facing wheels, rolling mill rollers tracks, sliding rollers, screws, mill crushing jaws and mill wheels, where excellent resistance to abrasion is required especially when accompanied by shocks, and blows, and for hard-facing wearing components such as excavation buckets and teeth and surfaces subject to abrasion and heavy loads. A cushion layer deposited with basic-coated electrode or basic flux cored wire is essential only with hard-to-weld steels. To be used under the shield of Ar+CO<sub>2</sub>.

## TYPICAL CHEMICAL COMPOSITION OF WIRE

C %	Mn %	Si %	S %	P %	Cr %	Ni %	Mo %	Cu %	V %
0.45	0.40	3.00	0.030	0.030	9.50	-	-	-	-

## TYPICAL MECHANICAL PROPERTIES

GAS		Hardness
		(HRc)
MIX	as welded	~ 58

## WELDING GUIDELINES

Machinability by grinding wheel and possible quenching at 880°C oil, annealing at 850°C.

## TECHNICAL INFORMATION

Gas: Mix Ar- CO<sub>2</sub> (EN ISO 14175)

Welding positions: all positions



## WELDING PARAMETERS

Current	DC + Reverse polarity		
		1.0	1.6
Diameter (mm)			
Volts (V)		17 ÷ 30	21 ÷ 34
Intensity (A)		90 ÷ 260	140 ÷ 340

Diam.	15kg Spool
1.0mm	INMHF6001015
1.6mm	INMHF6001615

TALARC Pty Ltd  
10-16 Syme St  
Brunswick, Vic 3056  
Ph. +61 3 9388 0588 Fax: +61 3 9388 0710  
W: [www.talarc.com](http://www.talarc.com) E: [sales@talarc.com](mailto:sales@talarc.com)