

NIMOTEN HFD

HARD FACING (High Temperature Oxidation - Impact - Abrasion)

ALLOY BASIS

C, Cr, Mo, W

KEY FEATURES:

- Heavy coated electrode
- Weld deposit with excellent toughness and hardness properties
- Superior metal to metal wear resistance at high temperatures
- Multipass crack free weld deposit maximum up to 15 mm


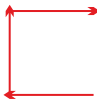
TYPICAL APPLICATIONS:

- For repair of large hot working dies, press forging dies
- Hot piercing punches, Impactor dies, Screw press dies
- Forming dies, Trimming dies, Blanking dies
- For H series tool steels such as H11, H12, H13
- Parts of earth moving equipment





MECHANICAL PROPERTIES OF ALL WELD METAL:

Condition	Hardness, 3 Layer HRc
As Welded	50 - 54

PARAMETERS - PACKING DATA:

Ø x L, mm 4.0 x 350 5.0 x 450 6.3 x 450	Amperage, A 140-180 190-230 260-320	 AC (70 V) / DCEP	All Positions, except vertical Downwards 
		REDRYING CONDITION: 300°C for 1 hr.	

Available in Standard carton packing of 20 kg box containing 4 cartons of 5 kgs each.

Machinability	Abrasion Resistance	Impact Resistance	Corrosion Resistance
			

Physical Properties: With increase in number of squares, property improves