



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, Typical
As Welded	50

PARAMETERS - PACKING DATA:

Ø x L, mm	Amperage, A	 AC (70 OCV) / DCEP REDRYING CONDITION: 250-300°C for minimum 1 hr.
3.15 x 450	100-140	
4.0 x 450	140-180	
5.0 x 450	190-230	
6.3 x 450	260-320	

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

Machinability	Abrasion Resistance	Impact Resistance	Corrosion Resistance
			

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