



# HI-ALLOY HFW-30

## BUILD-UP WIRE

**DESCRIPTION:** Hi-Alloy HFW-30 is a metal cored, gas shielded, low alloy wire with very good compressive strength and resistance to plastic deformation. It can be used on both carbon and low alloy steels, is an ideal base for subsequent overlay with a more wear resistant alloy, and it is also good for use where a tough but machinable weld deposit is required.

**WELDING PARAMETERS:** Use DC Reverse Polarity

	Short Arc		Spray Arc	
Diameter	.045	.062	.045	.062
Amps	90-200	150-220	250-325	300-375
Volts	15-21	18-21	27-30	27-30
Stick-out	1/2"	3/4"	5/8"	3/4"
Shielding Gas	Ar/CO <sub>2</sub>	Ar/CO <sub>2</sub>	Ar/Ox	Ar/Ox
CFH	25/30	25-30	40-45	40-45

Note: When welding out of position use lower ranges of volts and amps.

**TYPICAL WELD METAL PROPERTIES:** Hardness 32 - 38 RC  
Unlimited Buildup Capability  
May Be Flame Cut  
Machinable with Carbide Tools

Available in 10# & 25# Spools