



HI-ALLOY HFW-354

MANGANESE ALLOY WIRE

DESCRIPTION: Hi-Alloy HFW-354 is a premium quality, fluxcored, open arc wire with excellent operating characteristics. This wire is an austenitic manganese steel, alloyed with chrome and nickel for advanced weld deposit qualities. This product may be used for joining and build-up of manganese steel, and for surfacing of carbon, and low alloy steels. The deposits work hardens readily and may be flame cut.

TYPICAL APPLICATIONS: Joining of manganese steels, and buildup of impact hammers, crusher rolls, bucket teeth, and railroad frogs and crossovers.

WELDING PARAMETERS: Use DC Reverse Polarity & Globular Metal Transfer

Diameter	.045	1/16
Amps	100-200	150-300
Volts	19-27	23-28
Stick-out	¾ - 1½"	1 - 1½"

NOTE: Shielding gas is not normally required but when welding out of position it is best to use a shield of 100% CO₂ gas at 40-45 CFH and DC Straight Polarity. No preheat is required, the heat input should be kept to a minimum, and the part should be allowed to cool slowly.

TYPICAL MECHANICAL PROPERTIES:

As Welded Hardness	15 - 20 RC
Work Hardens to	50 - 55 RC
Tensile Strength	120,000 psi
Yield Strength	75,000 psi
Elongation	45%

Available in 10# & 25# Spools

NOTE: This product is not recommended for use in applications where machining of the weld deposit is required.