



## HI-ALLOY HFW-50

### MEDIUM CHROME CARBIDE ALLOY

**DESCRIPTION:** Hi-Alloy HFW-50 is a metal-cored alloy that can be used either with or without a gas shield. It has a medium percentage of chrome carbide particles combined with a tough bonding matrix. It is useful for applications involving high impact and moderate abrasion. The deposited metal is tougher than standard chromium carbide alloys and will stress relieve with fewer check cracks.

**TYPICAL APPLICATIONS:** Use as a final overlay for applications involving high impact and crushing such as; Impact breaker bars and pulverizing hammers, hammer mill hammers, crusher jaws, and cone and roll shells.

**WELDING PARAMETERS:** Use DC Straight or Reverse Polarity

Diameter	.045	.062
Amps	100-250	160-300
Volts (DCRP)	15-26	20-25
Stick-out	¾-1"	1-1½"
Shielding Gas	NOT REQUIRED	

**NOTE:** There may be situations where a shielding gas may be helpful. On these occasions use of Argon/CO<sub>2</sub> or a 100% CO<sub>2</sub> shielding gas is recommended. This will cause amperages to go up by about 10% and the stick-out should be shortened. When welding out of position is required use the lower ranges of the volts and amps, a gas shield may also be helpful.

**TYPICAL WELD METAL PROPERTIES:** Hardness 47 - 52 RC  
Non-Machinable  
Deposit Thickness 3 - 5 Layers  
Cannot Be Flame Cut

Available in 10# and 25# spools