



HI-ALLOY HFW-57

HARDFACING WIRE

DESCRIPTION: Hi-Alloy HFW-57 is an excellent general purpose, metal-cored, gas shielded hardfacing alloy. This product features good resistance to abrasion, exceptional toughness, and good metal to metal wear. The deposits are not brittle and exhibit characteristics similar to H-13 tool steel when in service, these characteristics allow the deposits to resist chipping and maintain a good cutting edge. The deposits are also heat resistant at temperatures up to 1100° F.

TYPICAL APPLICATIONS: Buckets and bucket teeth, coal chutes, augers, screw conveyors, dozer and scraper blades, hot shear blades, gripper dies, shearing and piercing dies, trim dies, forging dies, recycling knives and cutting tools.

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 ₂	Ar/CO ₂	Ar/Ox	Ar/Ox
CFH	25-30	25-30	40-45	40-45

TYPICAL WELD METAL PROPERTIES: Hardness 55 - 59 RC
Non-Machinable
Maximum Deposit Thickness 3 Layers
May be Flame Cut

Available in 10# and 25# spools