



HI-ALLOY HFW-59

HARDFACING WIRE

DESCRIPTION: Hi-Alloy HFW-59 is an excellent general purpose, metal-cored, gas shielded hardfacing alloy. This product combines outstanding resistance to abrasion and impact with exceptional resistance to chipping and spalling. This very versatile alloy is for use on carbon and low alloy steels, develops full hardness in its first pass but may be applied up to 3 passes, provides excellent out of position weldability, and the deposits are 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 and has a variety of agricultural uses.

WELDING PARAMETERS: Use DC Reverse Polarity

	Short Arc		Spray Arc	
Diameter	.045	.062	.045	.062
Amps	125-175	160-200	200-260	240-290
Volts	17-19	19-21	26-29	28-30
Stick-out	1/2"	3/4"	5/8"	3/4"
Shielding Gas	Ar/CO ₂	Ar/CO ₂	Ar/Ox	Ar/Ox
CFH	30-35	25-30	40-45	40-45

NOTE: When welding out of position is required use the lower ranges of volts and amps.

TYPICAL WELD METAL PROPERTIES: Hardness 58 - 60 RC
 Non-Machinable
 Maximum Deposit Thickness 3 Layers
 May be Flame Cut

Available in 10# and 25# spools