



HI-ALLOY HFW-63

PREMIUM CHROME CARBIDE ALLOY

DESCRIPTION: Hi-Alloy HFW-63 is a metal-cored alloy that can be used either with or without a gas shield. It has a high percentage of chrome carbide particles combined with a hard bonding matrix. It is useful for applications involving high abrasion and moderate impact. This alloy is for use on carbon and low alloy steels, is heat resistant at temperatures up to 1000° F, and the deposit will polish to a highly friction resistant surface.

TYPICAL APPLICATIONS: Buckets and bucket teeth, coal chutes, augers, screw conveyors, dozer and scraper blades, tilling tools, fan and mixer blades.

WELDING PARAMETERS: Use DC Straight or Reverse Polarity

Diameter	.045	.062
Amps	140-200	170-300
Volts (DCRP)	18-24	22-28
Stick-out	¾-1"	1-1½"
Shielding Gas	NOT REQUIRED	

NOTE: When welding out of position is required use .045 diameter with DC Reverse polarity and the lower ranges of volts and amps. Welding vertical down is accomplished with ¾" weave beads; use of a 100% CO₂ or 75% Argon 25% CO₂ gas shield will be helpful.

TYPICAL WELD METAL PROPERTIES: Hardness 58 - 62 RC
Non-Machinable
Maximum Deposit Thickness 2 Layers
Cannot Be Flame Cut

Available in 10# and 25# spools