



HI-ALLOY HF-64

HIGH HARDNESS OVERLAY

DESCRIPTION: Hi-Alloy HF-64 is a metal-cored alloy that can be used either with or without a gas shield. It is useful for applications involving high abrasion and moderate impact, and retains good hot hardness up to 1100° F. This alloy is well suited for use on carbon and alloy steels, manganese steels, and cast irons where a non-machinable deposit may be employed.

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 Reverse Polarity

| | Short Arc | | Spray Arc | |
|---------------|----------------------------|---------|---------------------|---------|
| Diameter | .045 | .062 | .045 | .062 |
| Amps | 130-180 | 160-210 | 200-280 | 260-320 |
| Volts | 17-23 | 19-23 | 28-30 | 29-31 |
| Stick-out | 3/4" | 1" | 5/8" | 3/4" |
| Shielding Gas | Not required for short arc | | 98% Argon/2% Oxygen | |
| CFH | N/A | N/A | 40-45 | 40-45 |

NOTE: While short arc welding, you may find applications where use of a shielding gas may be helpful. For these applications 75% Argon 25% CO₂ or 100% CO₂ would be recommended. If a shielding gas is used the amperages will go up by about 10% and the stick out should be shortened. When out of position welding is required, use the lower range of amps and volts, and a gas shield may also be helpful.

TYPICAL WELD METAL PROPERTIES: Hardness 60 - 65 RC
 Non-Machinable
 Maximum Deposit Thickness 2 Layers
 Cannot Be Flame Cut

Available in 10# and 25# spools