



## HI-ALLOY HFW-66

### PREMIUM MULTI-CARBIDE ALLOY

**DESCRIPTION:** Hi-Alloy HFW-66 is a metal-cored alloy that can be used either with or without a gas shield. It has a high percentage of mixed multi-carbide particles combined with a hard bonding matrix. It is useful for applications involving severe abrasion coupled with high stress grinding, and even low stress scratching and gouging. This alloy is for use on carbon and low alloy steels. The deposits are heat resistant at temperatures up to 1400° F., will likely double the wear resistance of chrome carbide overlays and in some applications HFW-66 may be used to replace tungsten carbide overlay products.

**TYPICAL APPLICATIONS:** Cement mill parts, coke pusher shoes, tong bits, brick making equipment, grain processing equipment, coal chutes, augers, screw conveyors, agricultural equipment, tilling tools, ash fans and mixer paddles.

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

Diameter	.045	.062
Amps	150-225	160-300
Volts (DCRP)	18-21	20-28
Stick-out	¾-1"	1-1½"
Shielding Gas	NOT REQUIRED	

**NOTE:** Even though a gas shield is not required with this product, there may be applications where a shielding gas may be helpful. For these situations use of 75% Argon 25% CO<sub>2</sub> or 100% CO<sub>2</sub> would be recommended. Use of shielding gas causes the amperage to increase so the stick-out should be shortened. When welding out of position is required use the lower ranges of volts and amps.

**TYPICAL WELD METAL PROPERTIES:** Hardness 63 - 67 RC  
Non-Machinable  
Maximum Deposit Thickness 2 Layers  
Cannot Be Flame Cut

Available in 10# and 25# spools