

Inweld Hardfacing FC Wires

Chemical Composition of Inweld Nickel 625

Fe	C	Cr	Ni	Mo	Mn	Si	P	S	N	Cu
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Single values are maximum unless otherwise specified.

Overview

There are significant benefits to using Inweld Flux-Cored wires to fill your hardfacing and buildup requirements. Use of flux-cored wires is generally less costly than using standard coated electrodes. There is virtually no waste since there is no stub loss with the use of continuous wire, the welder wastes no time changing electrodes, and unlike other similar products, Inweld flux-cored hardfacing wires are designed to be used with 100% CO₂ instead of more expensive shielding gases. Flux-Cored wires produce minimal slag, which shortens the cleanup time and increases productivity. Another benefit is less base metal fatigue. Flux-cored wires generally require less amperage than their coated electrode counterparts decreasing heat input. The additional stresses created by stopping the procedure to change electrodes and the amperage surge of re-strike are avoided.

Recommended Parameters

Process: GMAW (DCReverse)

Polarity: DC Reverse

Shielding Gas: 100% CO₂

<u>Wire Diameter</u>	<u>Voltage</u>	<u>Amperage</u>
0.045"	21-26	150-250
1/16"	23-28	250-350

Inweld HT 350 Descriptions and Parameters

Inweld HT 350 is a general purpose product which is useful for both build-up and hardsurfacing. The medium hardness martensitic deposit allows this product to provide good resistance to heavy impact and light to moderate abrasion. Deposits are tough, but machinable and forgable.

Typical Applications: Buildup and overlay on carbon steel shafts, steel shovels, gear teeth and sprockets

Hardness: Rockwell C 34-39

Inweld HT 600 Descriptions and Parameters

Inweld HT 600 is designed to provide deposits resistant to high abrasion, heavy impact, and corrosion. This product may be used on carbon, low alloy and manganese steels to provide resistance to metal to metal wear and is useful for quarry and agricultural applications.

Typical Applications: Plow points, discs, drag lines, bucket lips and teeth, crushers and extruder screws

Hardness: Rockwell C 53-56

Inweld HT 700 Descriptions and Parameters

Inweld HT 700 deposits are the hardest currently available in our hardfacing, flux-cored product line. It is especially suited for metal to metal wear but also boasts excellent abrasion and impact resistance.

Typical Applications: Crusher rolls, mill hammers, conveyor rollers and screws.

Hardness: Rockwell C 58-61

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