

ES HF 45-H

SMAW

ESWECO
The Art of Welding

Type Low hydrogen, potassium

EDZCr-B-16

Description

ES HF 45-H is used for hardfacing and repairing blades of hydro-turbine, Parts of high pressure pumps and charging cones of blast furnace that work condition of normal temperature and high temperature abrasion and corrosion.

The deposited metal has good performance of abrasion-resisting and cavitation erosion-resisting.

Notice: The rod should be redrying at 350 °C for 1 hour before use.

Current

AC, DC+



Classifications

GB/T 984 EDZCr-B-16

Typical all weld metal composition, %

C	Mn	Cr	Other
2.2	0.12	29.0	2.3

Typical mech. Properties all weld metal

Hardness, HRC 45-51

Welding parameters

Diameter, mm	Length, mm	Welding current, A	Arc voltage, V
3.2	350	90-130	24
4.0	400	130-180	26
5.0	400	150-180	27