

ES HF 40-B

Type Lime-titania

SMAW

EDPCrMo-A3-03

ESWECO
The Art of Welding

Description

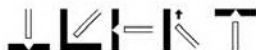
ES HF 40-B is used for hardfacing and repairing abraded parts of gears, dredger buckets, furrow ploughs and drawing templates of mining machineries and agriculture machineries.

Notice: The rod should be redrying at 150 °C for 1 hour before use.

To avoid cracks the base metal should be preheated to 300°C before welding.

Current

AC, DC+



Classifications

GB/T 984 EDPCrMo-A3-03

Typical all weld metal composition, %

C	Cr	Mo
0.34	2.3	1.9

Typical mech. Properties all weld metal

Hardness, HRC 40-50

Welding parameters

Diameter,mm	Length,mm	Welding current, A	Arc voltage,V
2.5	300	60-80	23
3.2	350	90-120	24
4.0	400	150-180	27
5.0	400	190-230	28