

ES HF 55

Type Lime-titania

SMAW

EDRCrMoWV-AI-03

ESWECO
The Art of Welding

Description

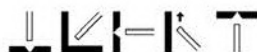
ES HF 55 is suitable for hardfacing punch dies, cutting tools as well as for hardfacing and repairing parts of machineries that need high abrasion resistance.

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 EDRCrMoWV-AI-03

Typical all weld metal composition, %

C	Cr	Mo	W	V
0.42	4.3	2.0	8.6	0.6

Typical mech. Properties all weld metal

Hardness, HRC 55-60

Welding parameters

Diameter,mm	Length,mm	Welding current, A	Arc voltage, V
2.5	300	60-80	24
3.2	350	90-120	26
4.0	400	160-190	27
5.0	400	190-230	30