

# ES HF 40-A

SMAW

**ESWECO**  
*The Art of Welding*

Type Low hydrogen, sodium

DGS K 501.41

## Description

ES HF 40 is suitable for surfacing sealing surface of high pressure valves that work temperature below 600 °C. The deposited metal has good performance of high temperature abrasion-resisting, good erosion resistance, good heat stability, good heat fatigue resistance and it has higher high temperature hardness. The deposited metal has obvious effect of aging time intensifying.

Notice: The rod should be redrying at 250 °C for 1 hour before use.

To guarantee hardness, the deposited metal should not be lower than 5 mm after machining & should not be too high to avoid cracks.

## Current

DC+



## Classifications

DGS K 501.41-2004

## Typical all weld metal composition, %

C	Si	Mn	Cr	Ni	Mo	Nb	W	V
0.13	2.6	1.4	16.0	9.63	6.1	0.73	2.0	0.68

## Typical mech. Properties all weld metal

Hardness, HRC 37-45

## Welding parameters

Diameter, mm	Length, mm	Welding current, A	Arc voltage, V
3.2	300	80-120	25
4.0	350	120-160	25
5.0	350	160-190	27