

Technical Data sheet	FLUX CORED WELDING WIRES HARDFACE HP	
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CLASSIFICATION		
EN 14700: T Fe15		
DESCRIPTION		
● Tubular wire for self-shielded metal arc hardfacing ● High chromium cast iron containing a high proportion of hard primary chromium carbide in a tough austenitic matrix ● The deposit is suitable for hardfacing components subject to extremely severe abrasive wear and moderate impact		
APPLICATIONS		
● HARDFACE HP1 series and HP2 series are used for hardfacing components undergoing severe slide abrasives and moderate impact ● HARDFACE HP3 series and HP6 series under high temperature working condition up to 600- 1000 °C as well as resist severe slide abrasives and moderate impact ● HARDFACE HP4 series and HP5 series for hard buffer on mills as transfer layer and cover layer		
Examples		
Industry Application	Power industry	Coal hopper lining plate , coal drop pipe liners, coal mill wear parts, ash pipeline, fan blade
	Iron and steel industry	Bin liner, skip car liner, vibrating feeder lining, CDQ tank lining, coke-barrier car bottom plate, slag sluice lining
	Cement industry	Raw mill lining, clinker chute lining, dust discharge pipe, guide vane, roller protection sleeve, slag mill wear parts
	Glass industry	Blender mixer bottom plate, fan blade, fore and rear discs of fan impeller, quick-wearing wear parts
	Mining industry	Excavator bucket liners, bucket-wheel excavator, scarper conveyor middle trough, elevator skip, hopper liner
	Engineering industry	Shield machine wear parts, boring machine shovel plate, loader shovel plate, dump truck body plate
	Port	Loading and discharging machine, wear-resistant pipeline, channel dredging, bin liner

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Self-Shielded Flux Cored Welding Wire

Item	Wire diameter (mm)	Alloy Chemical Ingredient (%)										Performance And Use
		C	Cr	Si	Mn	B	Mo	Nb	W	V	Ni	
HP124	2.4-3.2	4.0-5.3	23-25	0.7-1.5	0.5-1.5	0.8-1.5						Wear-plate surfacing single-layer welding wire is suitable for low stress abrasive wear conditions
HP128	2.4-3.2	4.2-5.5	27-29	0.5-1.5	0.5-1.5	0.8-1.5						
HP130	2.4-3.2	4.2-5.5	29.5-30.5	0.5-1.5	0.5-1.5	0.8-1.5						
HP220	2.4-3.2	4.0-5.0	19.5-20.5	0.7-1.5	0.7-1.5	0.4-0.7						Wear-resistant plate surfacing welding double layer and above. The welding wire is suitable for medium impact wear condition
HP224	2.4-3.2	4.0-5.3	23-25	0.7-1.5	0.7-1.5	0.4-0.7						
HP228	2.4-3.2	4.2-5.5	27-29	0.5-1.5	0.7-1.5	0.4-0.7						
HP230	2.4-3.2	4.2-5.5	29.5-30.5	0.5-1.5	0.7-1.5	0.4-0.7						
HP236	2.4-3.2	4.2-5.5	35.0-37.0	0.5-1.5	0.7-1.5	0.4-0.7						
HP300	2.4-3.2	4.2-5.5	24-27	0.5-1.5	0.7-1.5	0.3-0.7	0.5-1.5	0.5-1.5	0.5-1.5	0.5-1.5		Resistant to high temperature condition of 600 degrees wear-plate surfacing welding wire
HP308	2.4-3.2	4.2-5.5	21-25	0.5-1.5	0.7-1.5	0.3-0.7	2.5-3.5	2.5-3.5	0.8-1.5	0.8-1.5		Resistant to high temperature condition of 800 degrees wear-plate surfacing welding wire
HP310	2.4-3.2	4.2-5.5	21-25	0.5-1.5	0.7-1.5	0.3-0.7	5.0-7.0	5.0-7.0	1.5-2.0	0.8-1.2		Resistant to 1000 ° C high temperature condition wear-plate surfacing welding wire

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HP4196	2.4-3.2	0.1-0.4	18-20	0.4-1.2	5.0-7.0						8.0-10.0	Surfacing Grinding Roller and Grinding Table
Item	Wire diameter (mm)	Alloy Chemical Composition (%)										Performance And Use
		C	Cr	Si	Mn	B	Mo	Nb	W	V	Ni	
HP4202	2.4-3.2	0.1-0.4	4.0-14.0	0.4-1.2	12.0-16.0		0.6-1.2					Surfacing Grinding Roller and Grinding Table
HP4226	2.4-3.2	4.2-6.0	25-29	0.7-2.0	0.7-2.0	0.3-0.5					0.3-0.6	Cement production wear、 Coal hopper、Mineral mechanical wear
HP4230	2.4-3.2	4.2-6.0	29-31	0.5-2.0	0.5-2.0	0.3-0.5					0.3-0.6	
HP4100	2.4-3.2	4.2-6.0	25-29	0.5-2.0	0.5-2.0	0.3-0.5	0.8-1.5				0.3-0.6	
HP4143	2.4-3.2	4.2-6.0	25-29	0.5-2.0	0.5-2.0	0.3-0.5			6.0-8.0		0.3-0.6	Mineral mechanical wear wire
HP4145	2.4-3.2	4.2-5.5	21-25	0.5-1.5	0.7-1.5	0.3-0.7	5.0-7.0	5.0-7.0	1.5-2.0	0.8-1.2	0.3-0.6	Blue carbon condition roller special welding wire
HP5100	2.4-3.2	4.2-6.0	25-29	0.5-2.0	0.5-2.0	0.3-0.5	0.8-1.5				0.3-0.6	Crushing roll surfacing welding wire
HP6300	2.4-3.2	4.2-5.5	24-27	0.5-1.5	0.7-1.5	0.3-0.7	0.5-1.5	0.5-1.5	0.5-1.5	0.5-1.5	0.2-0.4	Single roller crusher teeth、 Grizzly bar、Distributor chute , etc. High temperature and wear resistant parts production and repair of surfacing welding wire
HP6308	2.4-3.2	4.2-5.5	21-25	0.5-1.5	0.7-1.5	0.3-0.7	2.5-3.5	2.5-3.5	0.8-1.5	0.8-1.5	0.2-0.4	
HP6310	2.4-3.2	4.2-5.5	21-25	0.5-1.5	0.7-1.5	0.3-0.7	5.0-7.0	5.0-7.0	1.5-2.0	0.8-1.2	0.2-0.4	

Structure: Primary carbides and eutectic carbides of the M_7C_3 type in austenitic matrix.

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness – single layer / multi-layer deposits on mild steel (ASTM A36/ Q235B): 58-62 HRc

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CONDITIONS OF USE	
Current Type	Protection
DC+	Self-shielded

WELDING POSITION
Flat, half up, half down

PACKING	
	Diameter 2.4-3.2 mm
Standard packing	25 kg/drum
Standard packing	250 kg/drum
Size	Range
2.8-3.2 mm	300-400A,29-30V

Welding products and techniques evolve constantly. All descriptions, illustrations and properties given in this data sheet are subject to change without notice and can only be considered as suitable for general guidance. This document is intended to help the user make the correct choice of product. it is his responsibility to assess its suitability for his intended application.

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