Stanvac® INTERNATIONAL

Product Data Sheet

Stavinox HF 650 LH

Hardfacing Electrode resistant to Abrasion

Description and Application: Basic coated low hydrogen hard surfacing electrode for tough - hard, impact tough and abrasive resistant surfacing on unalloyed and low Alloyed materials. The weld metal is workable only by grinding. Recommended For surfacing on machine parts, dredge teeth, beater bars, Scrapers, rock drills, drill bits, coal cutter blade, excavator teeth, conveyor worms, mill hammers, mixer arms, crusher jaws and cones etc.

Typical weld metal Chemical composition (%) & Hardness

C	Si	Mn	Cr	V	Hardness, 2nd layer
0.3 – 0.6	0.5 - 0.8	0.3 – 0.6	5.0 – 7.0	0.3 – 0.6	55 - 60

Welding Current Amperes (A)

3.15	4.00	5.00
100 - 140	140 - 180	180 - 240

Welding instruction Redrying, if necessary, 2h / 250 - 300 °C. On materials sensitive to cracks use a buffer-layer of 18/8 Mn type is recommended. Low alloyed, high carbon tool steels etc, have to be preheated to 200 - 400 °C, depending on their composition and thickness. Slow cooling in still air after surfacing.

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