

## PRODUCT INFORMATION

### SIFTRODE HF-600

EN ISO 14700-A E Fe8  
DIN 8555 E 6-UM-60

## DESCRIPTION

Hardfacing general purpose electrode providing 57 – 62 HRC hardness. Recommended for elements exposed on heavy impact and medium abrasion. The deposit can be grinded and gouged.

## WELDING POSITIONS



Welding current: DC+  
Suitable welding positions PA, PB and PC

## TYPICAL WELD METAL COMPOSITION

C	0.50 %
Cr	5.0 %

## TYPICAL MECHANICAL PROPERTIES

0.2% Yield Strength	
Ult Tensile Strength	
Elongation	
Redrying	400°C / 1H or 300°C / 2h

## MATERIAL TO BE WELDED

To be used on base materials of steel and cast steels.

## AVAILABLE FORMATS

ELECTRODE RODS (MMA / SMAW)			
Dia	2.5kg Pkt	5.0kg Pkt	Approx Pcs/KG
3.2mm		RE6003250	27
4.0mm		RE6004050	14
5.0mm		RE6005050	9

CURRENT RANGE	
Dia (mm)	Amps
3.2	100-135
4.0	140-180
5.0	180-230

For further information, contact Weldability | Sif technical support on **0870 330 7757** or email **service@wholeweld.co.uk**

Doc Ref : SIF/PI/RE600  
Updated March 2017



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