

MF - 600

HARDFACING SHOCK AND ABRASION RESISTANT HARDFACING ALLOY



- Gives superior shock and abrasion resistance
- Ideal for crushing equipment
- Excellent for overlaying in vertical and horizontal positions

IMPACT RESISTANT HARDFACING ALLOY

- MF 600 gives maneuverability in welding positions for overlaying
- MF 600 has an unusual ability to resist both shock and abrasion
- MF 600 - Up to 10 pass build-ups without weld cracking
- MF 600 - Welds pass over pass without chipping slag



MF-600

SPECIAL BENEFITS

- **MF 600** hardfacing is a low cost method of increasing uptime and extending service life
 - **MF 600** hardfacing reduces overall production cost
 - **MF 600** does not require chipping of slag
 - **MF 600** is quality engineered specially for maximum service and ease of application
 - **MF 600** does not cause any problems in overlays
 - **MF 600** is the ultimate solution for crushing equipment up keep
 - **MF 600** gives maximum impact resistance
 - **MF 600** gives utmost weld-ability
 - **MF 600** cuts down your replacement costs considerably and increases production time
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OUTSTANDING PROPERTIES:

- Provides built-in resiliency for unprecedented impact resistance. Stress relieves itself
- Much sought after solution for crushing equipment
- Gives fantastic deposition rate for a hard surfacing electrode
- Has highly efficient arc without spatter and slag
- Electrode with pleasing operating characteristics like smooth and stable arc
- Gives maneuverability in welding positions
- 9% chromium which is highly resistance to severe abrasion and moderate impact
- Thoroughly tested for its performance

APPLICATIONS

Restoring worn equipment Such as:

- Agitator blades in machines
- Impact breaker rotors and bars
- Grader blades
- Screens
- Conveyor buckets
- Steel debarking tools
- Scarifier teeth
- Power shovel teeth
- Skip hoists
- Sheepsfoot tamps
- End bits

MICROSTRUCTURE: Martensite with some carbides

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MECHANICAL PROPERTIES:

Undiluted Weld Metal	Maximum Value Up to:
Hardness:	Rockwell C 56-57
Wear Co-efficient:	2.2%

RECOMMENDED CURRENT: DC Reverse (+), or AC

RECOMMENDED AMPERAGE SETTINGS:

Diameter in (mm)	3/32 (2.5)	1/8 (3.25)	5/32 (4.0)	3/16 (5.0)
Minimum Amperage	80	100	140	180
Maximum Amperage	100	140	180	230

WELDING POSITIONS : Flat, Horizontal, Vertical up

WELDING TECHNIQUES:

Weld in a stringer or 3X weave fashion. When welding vertically use the "whip" technique.

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