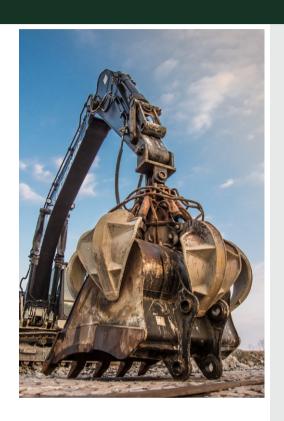
MF - 600

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 - SHOCK AND ABRASION RESISTANT HARDFACING ALLOY

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

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

Email: info@microfusionweld.com

Web: www.microfusionweld.com

- Grader blades
- Screens
- Conveyor buckets

- Steel debarking tools
- Scarifier teeth
- Power shovel teeth
- Skip hoists
- Sheepsfoot tamps
- End bits

MICROSTRUCTURE: Martensite with some carbides





MF 600 - SHOCK AND ABRASION RESISTANT HARDFACING ALLOY

MF-600

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.

