



HILCO HILCORD 600

Cored wires – repair & maintenance – wear resistant

EN 14700: T Fe 6

DIN 8555: MSG 6 – GF – 60 -GP

Werkstoffnr. 1.4718

Wire type:

Metal cored wire

Current:**Welding positions:****Shielding gas:**

M21

Hilcord 600 is our seamless metal cored copper coated wire for wear resistant surfacing parts of steel, cast steel and high Mn-steel, subject to abrasion, metal-to-metal wear, impact and/or compression stresses. Deposit weld metal has a martensitic structure, hardness of pure weld deposit approx. 600HB. After welding the deposit can be machined by grinding only.

Applications:

Hilcord 600 is particularly suitable under conditions of heavy abrasion and friction, combined with impact. Ideally suitable for applications involving rolling, sliding and metal-to-metal wear.

Applications are universal but typical for hardfacing parts e.g. agricultural, earth moving and stone crushing industry, hardfacing crane and mine car wheels, sprockets and gear teeth, skip guides, dredger buckets, scrapper blades, transfertables, cable sheaves, tractor and shovel parts, dragline buckets, conveyor chains, hammer heads, clutch jaws.

Chemical composition, wt. % weld metal – typical:

C	Mn	Si	Cr	Mo
0,50	1,50	0,60	5,50	0,60

Mechanical properties, weld metal – typical:

Condition	Hardness
As welded	57 – 62 HRc

Packaging and welding data:

Dia. mm.	Spool type	Weight / spool kgs.	Current A	Voltage V
1,2	B300	16	50-320	12-35