

Introduction

HFK 155-G is a CO₂ gas-shielded flux cored wire that produces slag. Its welding performance is excellent without much splatter, its arc is stable, slag removal is easy, and the weld metal shows some work hardening after impact.

Abrasion	
Impact	
Heat	

Typical Applications

This welding wire is suitable for high impact wear surfacing, such as that for shield machine head surfacing. It can also be used for coal, ore loader hoppers, and cutting edge welding repair.

Chemical composition of deposited metal (%)

C	Cr	Mn	Mo	V	Si	Fe
0.4	6.5	1.0	0.5	0.5	1.0	Balance

Mechanical Properties

Layers	Hardness (HRC)
Before impact	50–55
After impact	55–58

Recommended welding parameters

DC reverse connection		
Diameter: in (mm)	Current (A)	Voltage (V)
0.045 (1.2)	160–220	22–25
1/16 (1.6)	200–280	22–28

Shielding Gas	Gas Flow: cfh (l/min)	Torch angle	Stick Out: in (mm)
100% CO ₂	40 (20)	80°	1/2–3/4 (15–20)

Diameters (mm) and Packaging

Diameter: in (mm)	Packaging: lb (kg)
0.045 (1.2)	33 (15)
1/16 (1.6)	33 (15)