

## Introduction

HFK 265B-G welding wire is a non-chromium, highly boron-alloyed cored wire for hardfacing with a stable arc and a good appearance after welding.

Abrasion	<div><div></div></div>
Impact	<div><div></div></div>
Corrosion	<div><div></div></div>

This welding wire is suitable for unalloyed steels in normal temperature. Due to its special microstructure, the deposited weld metal has excellent resistance to abrasion with moderate impact.

## Typical applications

For parts subjected to wear in machinery for the mine industry and agriculture.

## Mechanical properties

Layers	Hardness (HRC)
2 Layers	60–65

## Recommended welding parameters

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

Shielding Gas	Gas Flow: cfh (l/min)	Torch angle	Stick Out: in (mm)
100% CO <sub>2</sub>	40 (20)	80°	$\frac{1}{2}$ – $\frac{3}{4}$ (15–20)

## Diameters and packaging

Diameter: in (mm)	Packaging: lb (kg)
0.045 (1.2)	33 (15)
$\frac{1}{16}$ (1.6)	33 (15)