

Introduction

HFK 270B-G welding wire is a highly boron-alloyed cored wire for hard surfacing against extreme mineral wear. It features less sputter during welding, a stable arc, and a good appearance after welding.

Erosion	
Impact	
Corrosion	

This welding wire is suitable for unalloyed steels in normal temperatures and the deposited weld metal has excellent resistance to erosion due to its special microstructure.

Typical applications

For parts subjected to wear in machinery for the mine industry and agriculture, screw conveyors, and hoppers.

Mechanical properties

Layers	Hardness (HRC)
2 Layers	65–70

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 and packaging

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