



**BLUE
DEMON™**
WELDING PRODUCTS

HARDFACE HC420

Welding Wire

<u>PRODUCT NAME</u>	<u>WELDING PROCESS</u>	<u>WELDING CURRENT</u>
HC420	Self Shielded (gasless) Can be used with 100%CO2	DCEN

DESCRIPTION

HardCover 420 (HC420) is a high chromium cast iron for hard surfacing components subject to extremely severe abrasive wear and moderate impact. The weld deposit contains a high proportion of hard primary chromium carbides in a tough austenitic matrix. HC420 is used for hardfacing components undergoing wear by earth, sand and abrasives.

Preheat and post heat according to the base material where necessary.

TYPICAL APPLICATIONS

- **Gyratory crusher cones and mantles**
- **Catalyst pipes and valves**
- **Slurry pipes and valve bodies**
- **Dredge pump bodies**
- **Sand dredge parts**
- **Extruder screws**
- **Mining and earth moving equipment**

TYPICAL WIRE CHEMISTRY

Cr - 5, Mn 1.5, Si 1.5, Cr 27, Fe BAL

TYPICAL MECHANICAL PROPERTIES

Hardness on 1 layer, HRC 55 - 60

Maximum of 3 layers. Hardness HRC 60-62

WELDING POSITIONS

F, H

WELDING DIAMETERS AND SUGGESTED OPERATING RANGE IN AMPS

1.2mm 100 – 300 Amps

Our products, and any recommended practices, should be tested by the user under actual service conditions to determine their suitability for any particular purpose. The results obtained using this product/information are affected by variables such as welding procedure, base material composition, operating temperature, weldment design, method of fabrication and service requirements which are beyond our control. It is the sole responsibility of the user to determine the serviceability of a structure using this product and the information contained in this data sheet.