Product names	Typical use & Redrying condition	Nominal hardness	Pol.	WP	Composition	
						C
HF-11	▪ Crusher hammers and crusher jaws ▪ 150~200℃x0.5~1h	Hv 250	AC DCEP	1F 1G	Ty	0.82
HF-12	▪ Ripper teeth, impellers and breakers ▪ 300~350℃x0.5~1h	Hv 500	AC DCEP	1F 1G	Ty	0.72
HF-13	▪ Valve seats and agitator propellers ▪ 300~350℃x0.5~1h	Hv 450	AC DCEP	1F 1G	Ty	0.13
HF-16	▪ Hot shears and hot dies ▪ 150~200℃x0.5~1h	Hv 300	AC DCEP	1F 1G	Ty	0.71
HF-30	▪ Crusher rotors and liners ▪ 300~350℃x0.5~1h	Hv 700	AC DCEP	1F 1G	Ty	5.00

Note: Welding tests are as per Kobe Steel's Standard. Ty: Typical (polarity: AC)

Identification color

Product names	1st	2nd
HF-11	Red	Black
HF-12	Red	Brown
HF-13	Red	Blue white
HF-16	Orange	Brown
HF-30	Red	Silver

(overlay weld metal mass%)						Weld metal hardness	
Si	Mn	Cr	Mo	V	Ni	PWHT (°Cxh)	Hv
0.39	13.88	-	-	-	-	AW	266
0.89	1.17	7.30	1.12	-	-	AW	532
						500x2	630
0.50	0.74	12.97	0.97	-	0.99	AW	420
						750x1	260
0.48	14.59	15.33	1.85	0.42	2.20	AW	306
0.42	1.23	30.5	-	-	-	AW	770

Packaging data

ϕ mm	2.6	3.2	4.0	5.0	6.0
HF-11	-	350	400	400	450
HF-12	300	350	400	400	450
HF-13	-	350	400	400	-
HF-16	-	300	350	350	-
HF-30	-	-	400	450	-
carton mm	270W, 100H, 330L	170W, 125H, 380L or 330L	170W, 120H, 430L or 380L	170W, 120H, 430L or 380L	170W, 110H, 480L