Product names	Typical use & Redrying condition	Nominal hardness	Pol.	WP	Composition	
						C
HF-240	▪ Gears and wheels ▪ 70~100℃x0.5~1h	Hv 240	AC DCEP	1F 1G 3G uphill 4G	Ty	0.09
HF-260	▪ Shafts, crane wheels and couplings ▪ 300~350℃x0.5~1h	Hv 260	AC DCEP	1F 1G 3G uphill 4G	Ty	0.17
HF-330	▪ Keys and clutch lugs ▪ 70~100℃x0.5~1h	Hv 330	AC DCEP	1F 1G 3G uphill 4G	Ty	0.10
HF-350	▪ Upper rollers and sprockets of bulldozers ▪ 300~350℃x0.5~1h	Hv 350	AC DCEP	1F 1G 3G uphill 4G	Ty	0.25

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

Identification color

Product names	1st	2nd
HF-240	Red	White
HF-260	Red	Green
HF-330	Red	Purple
HF-350	Orange	Green

(overlay weld metal mass%)			Weld metal hardness		
Si	Mn	Cr	PWHT	Hv	Pre. H & IPT ℃
0.58	0.58	0.81	AW	240	150min.
			900℃, OQ	350	
0.69	1.81	-	AW	271	150min.
			900℃, OQ	395	
0.69	0.86	2.29	AW	340	150min.
			-	-	
0.49	1.38	1.16	AW	366	150min.
			850℃, OQ	510	

Packaging data

ϕ mm	2.6	3.2	4.0	5.0	6.0
HF-240	-	350	400	400	450
HF-260	300	350	400	400	450
HF-330	-	350	400	400	450
HF-350	300	350	400	400	450
carton mm	270W, 90H, 330L	170W, 120H, 380L	170W, 120H, 430L	170W, 120H, 430L	170W, 110H, 480L