Product names	Typical use & Redrying condition	Nominal hardness	Pol.	WP	Composition	
						C
HF-450	▪ Idlers, rollers and truck links of bulldozers ▪ 300~350℃x0.5~1h	Hv 450	AC DCEP	1F 1G	Ty	0.20
HF-500	▪ Idlers and truck links of bulldozers ▪ 300~350℃x0.5~1h	Hv 500	AC DCEP	1F 1G	Ty	0.45
HF-600	▪ Lower rollers and bucket edges ▪ 300~350℃x0.5~1h	Hv 600	AC DCEP	1F 1G	Ty	0.48
HF-650	▪ Tamping dies and mixer blades ▪ 300~350℃x0.5~1h	Hv 650	AC DCEP	1F 1G	Ty	0.67

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

Identification color

Product names	1st	2nd
HF-450	Red	Pink
HF-500	Orange	Blue white
HF-600	Red	Red
HF-650	Red	Orange

(overlay weld metal mass%)						Weld metal hardness		
Si	Mn	Cr	Mo	V	W	PWHT (°Cxh)	Hv	Pre. H & IPT ℃
1.30	0.31	2.54	0.60	0.23	-	AW	456	150min.
						550x6	443	
1.37	0.91	-	0.98	0.28	-	AW	517	150min.
0.77	2.58	2.50	-	-	-	AW	595	200min.
0.90	0.87	4.91	1.17	0.55	1.42	AW	634	200min.
						600x1, AC	580	

Packaging data

ϕ mm	2.6	3.2	4.0	5.0	6.0
HF-450	-	-	400	400	450
HF-500	-	350	400	400	450
HF-600	300	350	400	400	450
HF-650	300	350	400	400	450
carton mm	270W, 100H, 330L	170W, 130H, 380L	170W, 120H, 430L	170W, 125H, 430L	170W, 115H, 480L