Product names	Typical use & Redrying condition	Nominal hardness	Pol.	WP	Composition C	
HF-700	▪ Cutter knives and casings ▪ 300~350℃x0.5~1h	Hv 700	AC DCEP	1F 1G	Ty	0.62
HF-800K	▪ Cutter knives and casings ▪ 300~350℃x0.5~1h	Hv 800	AC DCEP	1F 1G	Ty	0.80
HF-950	▪ Shovel teeth and cutter knives ▪ 150~200℃x0.5~1h	Hv 950	AC DCEP	1F 1G	Ty	3.5

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

Identification color

Product names	1st	2nd
HF-700	Orange	Orange
HF-800K	Orange	Yellow
HF-950	Orange	-

(overlay weld metal mass%)						Weld metal hardness		
Si	Mn	Cr	Mo	W	B	PWHT (℃xh)	Hv	Pre. H & IPT ℃
0.80	0.78	5.12	2.21	-	-	AW	654	200min.
						600x1, AC	485	
1.65	1.24	3.82	-	2.42	0.29	AW	736	200min.
						600x1, AC	535	
0.1	2.6	-	-	26	-	AW	930	300min.

Packaging data

ϕ mm	3.2	4.0	5.0	6.0
HF-700	-	400	400	450
HF-800K	350	400	400	450
HF-950	-	400	400	-
carton mm	170W, 120H, 380L	170W, 115H, 430L	170W, 120H, 430L	170W, 120H, 480L