

**PRIME
WELD**

PRIME H600

For Hard Surfacing

CLASSIFICATIONS:
EN ISO 14700: E Fe6
JIS Z3326: YF3B-C-600

PRIME H600 is a gas-shielded flux cored wire that is suitable for stronger intermetallic and soil abrasion with light impact. Ideal for application such as various wheels bucket edges, sprockets and dipper teeth. In order to minimize cracking, should obey the preheat and interpass temperature.

TYPICAL ALL WELD METAL COMPOSITION (Wt%)					
Shielding gas	C	Mn	Si	Cr	Mo
CO ₂	0.45	1.21	0.55	4.11	0.55

HARDNESS OF WELD METAL				
WELDING CONDITION		VICKERS (Hv)	ROCKWELL (H _{RC})	SHORE (Hs)
As Welded	Preheating-Interpass Temp. 200-300°C	550-620	54-60	70-75

- Single layer deposit hardness may vary depending on the base metal type and degree of dilution.

SIZES AND RECOMMENDED CURRENT RANGE (DC+)		
DIAMETER Ø	1.2mm	1.6mm
Voltage (V)	23-33	27-35
Current (A)	140-220	200-300
Spool (Kg)	15	15