

+ Orange HF-I (AWS Spec. ●)

C %	Mn %	Si %	S %	P %	Cr %	Ni %	Mo %	Cu %	Fe %	Y.S N./mm <sup>2</sup>	UTS N./mm <sup>2</sup>	Elongation % L = 4D	Impact / Joules	Testing Temp
●	●	●	●	●	●	●	●	●	●	●			275 BHN Approx (3rd Layer Mild Steel)	●

Application:

Rail joints & crossings, Wheels, Gear shafts, couplings, rollers & sprockets, Hard facing & building up of shafts, scrappers, hammers, wagon wheels.

+ Orange HF-II (AWS Spec. ●)

C %	Mn %	Si %	S %	P %	Cr %	Ni %	Mo %	Cu %	Fe %	Y.S N./mm <sup>2</sup>	UTS N./mm <sup>2</sup>	Elongation % L = 4D	Impact / Joules	Testing Temp
●	●	●	●	●	●	●	●	●	●	●			405 BHN Approx (3rd Layer Mild Steel)	●

Application:

Application in which abrasion resistance with toughness is required, Welding couplings, conveyor parts, gear shafts, shear blades, pulleys, steel castings.

+ Orange HF-III (AWS Spec. ●)

C %	Mn %	Si %	S %	P %	Cr %	Ni %	Mo %	Cu %	Fe %	Y.S N./mm <sup>2</sup>	UTS N./mm <sup>2</sup>	Elongation % L = 4D	Impact / Joules	Testing Temp
●	●	●	●	●	●	●	●	●	●	●			610 BHN Approx (3rd Layer Mild Steel)	●

Application:

Hard facing machine parts, surfacing, rebuilding crushers, hammers, cane cutting lines, conveyor buckets, drilling bits, oil expellers, mine rails, mixer blades.

+ Orange HF-III LH (AWS Spec. ●)

C %	Mn %	Si %	S %	P %	Cr %	Ni %	Mo %	Cu %	Fe %	Y.S N./ mm <sup>2</sup>	UTS N./mm <sup>2</sup>	Elongation % L = 4D	Impact / Joules	Testing Temp
●	●	●	●	●	●	●	●	●	●	●			600 BHN Approx (3rd Layer Mild Steel)	●

Application:

Cane cutting knives, bamboo chippers knives, hammer, metal cutting tools, earth moving equipment, crusher hammers, punching dies.

+ Orange HF-V (AWS Spec. ●)

C %	Mn %	Si %	S %	P %	Cr %	Ni %	Mo %	Cu %	Fe %	Y.S N./ mm <sup>2</sup>	UTS N./mm <sup>2</sup>	Elongation % L = 4D	Impact / Joules	Testing Temp
●	●	●	●	●	●	●	●	●	●	●			600 BHN (3rd Layer Mild Steel)	●

Application:

Specially suited concrete mixer blades, oil expeller worm, screw conveyor, scrapper blades, cement dia rings, Earthmoving equipments, bucket teeth, muller tyres.

+ Orange HF-MANGAN (AWS Spec. ●)

C %	Mn %	Si %	S %	P %	Cr %	Ni %	Mo %	Cu %	Fe %	Y.S N./ mm <sup>2</sup>	UTS N./mm <sup>2</sup>	Elongation % L = 4D	Impact / Joules	Testing Temp
●	●	●	●	●	●	●	●	●	●	●			200-500 BHN (Work Hardness)	●

Application:

Specially suited for resurfacing of Worn-out austenitic Mn steel (Mn 12-14%), Hardfacing crusher jobs and hammers, Mn steel rails, rail erosion, austenitic Mn steel castings, crusher mantles, stone crusher jaws.

+ Orange HF-Chromang (AWS Spec. ●)

C %	Mn %	Si %	S %	P %	Cr %	Ni %	Mo %	Cu %	Fe %	Y.S N./ mm <sup>2</sup>	UTS N./mm <sup>2</sup>	Elongation % L = 4D	Impact / Joules	Testing Temp
●	0.25	5.50	0.50	0.03	0.03	16.5	●	●	●	●			200-500 BHN (Work Hardness)	●

Application:

Tractor Grouzers, Charging rams, Dipper teeth

+ Orange HF-Nichrome (AWS Spec. ●)

C %	Mn %	Si %	S %	P %	Cr %	Ni %	Mo %	Cu %	Fe %	Y.S N./ mm <sup>2</sup>	UTS N./mm <sup>2</sup>	Elongation % L = 4D	Impact / Joules	Testing Temp
●	0.25	2.50	0.20	0.03	0.03	17-20	4.00	●	●	●			200-500 BHN (Work Hardness)	●

Application:

Rock crushers, Coal mining cutters, Charging Rams.