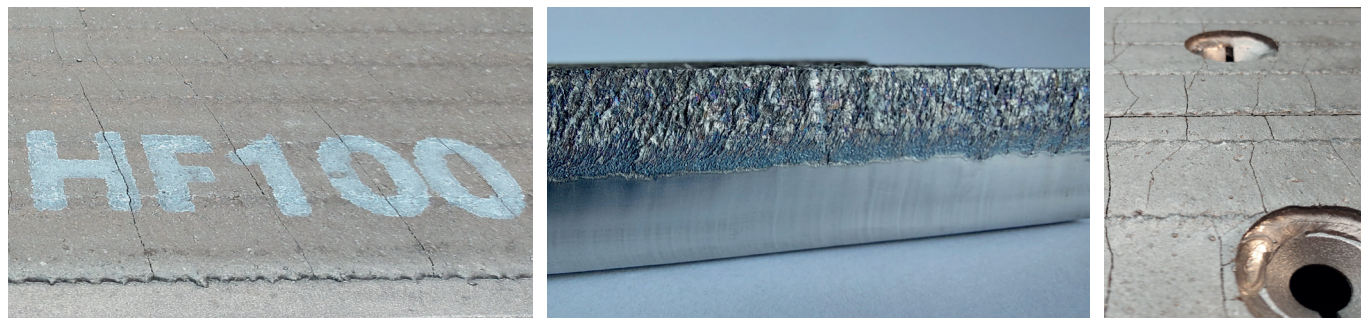


HARDFACING OVERLAY PLATES

Miilux® HF100, HF200, HF300



General product description

Miilux® HF100

Hardfacing overlay plate of general purposes. Especially suitable for severe abrasive wear and moderate impact. The structure is based on austenitic matrix enriched by dominant volume of Cr carbides complex. Fully applicable up to temperature of max 300 °C.

Miilux® HF200

Hardfacing overlay of special purposes. Especially suitable for severe abrasive wear and heavier impact. The structure is based on austenitic matrix enriched by dominant volume of Cr and Nb carbides complex. Fully applicable up to temperature of max 400 °C.

Miilux® HF300

Hardfacing overlay of special purposes and hot operations. Especially suitable for severe abrasive wear and moderate impact. The structure is based on austenitic matrix enriched by dominant volume of Cr, Nb, W and V carbides complex. Fully applicable up to temperature of max 500 °C.

Applications

High quality hardfacing overlay plates Miilux® HF are used especially in these kinds of industries: - cement, - building, - power, - quarries and mines, - gravel pits, - recycling, - glass, - steel works, - paper and pulp mills, - raw materials handling

In these typical apps: - silos, - bunkers, - chutes and hoppers liners, - conveyors, - excavator buckets and loader shovels, - vibrating screens and plates, - fan pads and liners, - crushers liners, - parts of drilling and dredging sets

Mechanical properties

	Hardness	Abrasive wear	Impact resistance	Application temperature
HF100	HRC 60-63	+++	+	+
HF200	HRC 62-65	+++	++	++
HF300	HRC 63-65	+++	+	+++

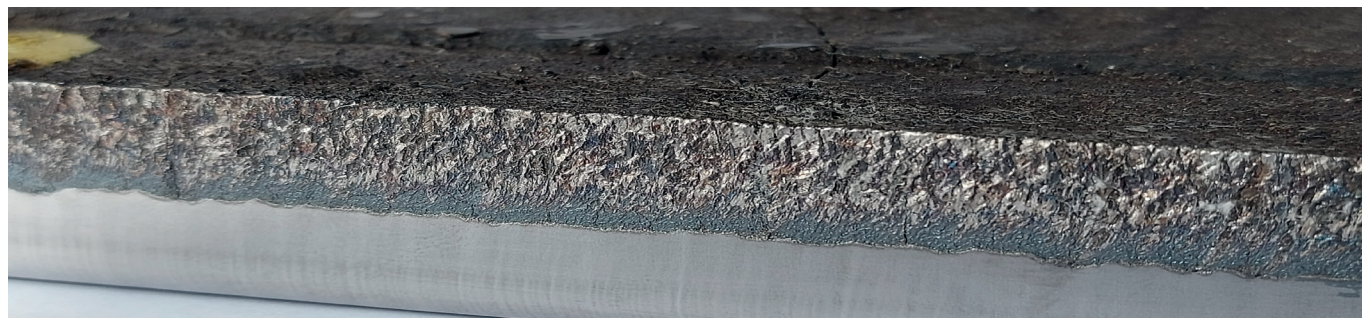
The hardness is measured on the clean milled and flat hardfacing overlay surface.

Chemical composition (max %)

	C	Cr	Mn	Si	B	oth	Fe
HF100	4,8%	32%	1,5%	0,8%	0,3%	1%	bal.
HF200	4,5%	23%	0,7%	0,8%	4,5%	0,4%	bal.
HF300	4,8%	22%	4,2%	3,4%	0,5%	0,9%	bal.

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Base plate

High quality hardfacing overlay plates Miilux® HF are produced by applying of abrasion-resistant material on mild steel base plate using traditional arc welding process.

	Steel base plate
HF100	S235/S355
HF200	S235/S355/P265GH (HII)
HF300	S235/S275/S355

Dimensions and delivery conditions

High quality hardfacing overlay plates Miilux® HF are produced standardly in the following combination of thicknesses:
base plate (mm) + hardfacing overlay (mm)

3+3, 5+3, 6+4

8+4, 8+5, 8+6, 8+7, 8+8

10+4, 10+5, 10+9, 10+5+5, 12+4

underlined = at stock

Plate dimensions: 1500x3000 mm with overlay surface 1400x2900 mm
(for 3+3 is valid 1500x2500 mm resp. 1400x2450 mm)

Other ticknesses combinations and plate dimensions can be discussed individually!

We will supply also Miilux® HF as ready to install parts and components according to your drawing or task to you. We will implenent individual wishes for marking, testing, packing and others in your order.

Miilux® HF is standardly delivered in as-welded condition.

Thickness and flatness tolerantions

Both total plate thickness and hardfacing overlay thickness are guaranted in range of -0 +1 mm of the nominal ones. Flatness is guaranted in range of ± 3 mm on the overall length of 3000 mm.

Processing and other recommendations

Oxy fuel cutting is not recommended. Also edges resp. surface grinding is not suitable. For welding, shaping or machining information please contact your local Miilux technical support.