

**PRIME  
WELD**

# PRIME H33-0

Flux Cored Wire  
For Hard Surfacing

Classifications:  
EN ISO 14700 : E Fe 14

Welding Positions:



## Characteristics and Applications:

**PRIME H33-0** is a self-shielded chrome carbide flux cored wire for hardfacing components subject to extremely severe abrasive wear and moderate impact and moderate corrosion resistance. The deposit contains high proportion of hard primary carbon and eutectic carbides in a tough austenitic matrix. Design to use in hardfacing palm oil mill screw and high pressure kernal worms. Ideal also palm oil expeller screw, dredge pump impellers, crusher cones and sugar mill crusher hammer.

## Chemical Properties of Weld Metal (Wt%)

C	Mn	Si	Cr	P	S
4.51	1.05	0.85	25.01	0.013	0.011

## Deposit Rating Scale

ABRASION	1	2	3	4	5	6	7	8	9	10
IMPACTS										
HEAT										
CORROSION										

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

Hardness (as-welded) : 58 - 63 HRC

Deposit thickness : 2 passes maximum

## Sizes Available and Recommended Currents (DC-)

Diameter (mm)	1.6	2.0
Current (A)	180-300	200-340
Voltage (V)	22-28	24-32
Spool (Kg)	15	15