



McKay HF-N

Replaces 081202

270-X Index: 090320

DESCRIPTION:

HF-N is a submerged arc flux designed for use with solid and tubular wires of the 400 series. It can also be used with low alloy wires. It has excellent recovery of alloying elements of the tubular wires, such as Cr, Ni, Mo, Nb and V. HF-N has excellent hot slag removal (up to 850° F) and can be used when welding with twin-arc or oscillating techniques. The weld beads are smooth and uniform and the weld metal has good wetting action.

TYPICAL DEPOSIT CHEMISTRY:

Product	C	Mn	P	S	Si	Cr	Ni	Mo	V	W	Nb	Rc
877-S	0.1	1.0	0.015	0.010	0.6	1.0	1.3	0.4	0.12			24
8620-S	0.06	1.4	0.015	0.010	0.8	0.5	0.4	0.2				21
861-S	0.15	0.9	0.015	0.010	0.5	1.7		0.6				32
242-S Mod	0.14	2.0	0.015	0.010	0.8	3.0		0.7				40
258-S	0.34	1.2	0.015	0.010	0.5	6.0		1.5		1.4		54
810-S	0.28	1.0	0.015	0.010	0.7	5.5		3.5				53
954-S	0.65	1.25	0.015	0.010	1.1	5.5		1.0			3.4	52
A2JL-S	0.04	0.8	0.015	0.010	0.6	13.5	2.0	0.9				35
868-S	0.04	0.8	0.015	0.010	0.6	13.0	4.5	1.0				40
410-S	0.08	1.0	0.015	0.010	0.6	12.8						36
A250-S	0.19	1.0	0.015	0.010	0.5	12.3						50
A420M-S	0.24	1.6	0.015	0.010	0.7	14.7		1.0				55
887-S	0.12	1.0	0.015	0.010	0.6	12.5	2.5	1.5	0.20		0.15	40
865-S Mod	0.18	1.1	0.015	0.010	0.4	13.5	2.3	1.0	0.15		0.15	48
952-S	0.27	1.2	0.015	0.010	0.6	12.8	0.5	1.8	0.15		0.15	49

PACKAGING:

Package	Pallet Wt.	Part Number
55 lb. Bag	2,200 lbs.	S669810-Z55

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