

HA - 1 - OPEN-ARC FLUX-CORED REBUILDING WIRE

CHARACTERISTICS:

- low alloy pearlitic steel with excellent endurance to **rolling loads**;
- offers exceptional structural strength and impact resistance;
- work hardens under load and can be multi-layered;
- rebuilds mild steel and low alloy steel;
- deposit is **machinable** and **can be flame cut**;
- excellent base for martensitic hardfacing material such as HA-3-MX Series
- excellent slag removal.

MECHANICAL PROPERTIES:

- 25 - 30 RC as deposited
- 40 - 45 RC work hardened

PROCEDURE:

	<u>.045"</u>	<u>.062"</u>
Voltage	24 - 28	26 - 30
Amperage	120-150	140 - 190
Optimum	26 - 140	28 - 170
Stick-Out	1" - 2"	1½" - 2"

- DC reversed polarity, 26-30 Volts, 250-350 Amps.(for larger diameters);
- remove all damaged material;
- avoid localized overheating of manganese steel by keeping bulk of part below 550°F;
- avoid thermal shock;
- stick-out: 2 - 3"

TYPICAL APPLICATIONS:

- mining car wheels, rail joints, tractor joints, tractor drive components, etc.

OTHER:

- Deposition Rate: 10 - 20 lbs./hr.;
- available in diameters of 7/64", 3/32", 5/64", 1/16" & .045";
- packaging: 28 lb. & 10 lb. spools, 55 lb. coils, 100, 250 & 450 lb. pay-off packs.

