

HA - 21

OPEN-ARC FLUX-CORED HARDFACING WIRE

CHARACTERISTICS:

- multi complex carbide deposit;
- superior high temperature (1400°F) abrasion resistance;
- contains amongst others, chromium, molybdenum, tungsten, & columbium;
- moderate impact strength;
- best results with limit of two layers;
- deposit is grindable only.

MECHANICAL PROPERTIES:

- 62 - 64 R.C. as deposited

PROCEDURE:

	<u>.045"</u>	<u>.062"</u>	<u>Large</u>
Voltage	24 - 30	26 - 30	28 - 32
Amperage	120-160	210-275	275-375
Optimum	29-150	28-230	30 -350
Stick-out	1" - 2"	12"-22"	2" - 3"

- remove all damaged material;
- avoid localised overheating of manganese steel by keeping bulk of part below 550°F;
- crack sensitive material should be preheated to 500-700°F depending on thickness & dimensions;
- avoid thermal shock;

TYPICAL APPLICATIONS:

- Wear plates, expeller screws, coal screens, bucket teeth, conveyors or rollers for hot plates, etc.

OTHER:

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

