

HA - 2

OPEN-ARC FLUX-CORED REBUILDING WIRE

CHARACTERISTICS:

- austenitic **manganese** steel;
- extremely tough and impact resistant;
- work hardens under load;
- can be **multi-layered**;
- rebuilds and joins 11-14% manganese steel;
- deposit is machinable before work hardening and **can be flame cut**;
- excellent base for hardfacing materials such as HA-4 series & HA-5;
- excellent slag removal.

MECHANICAL PROPERTIES:

- 15 - 18 RC as deposited
- 50 - 55 RC work hardened

PROCEDURE:

	<u>.045"</u>	<u>.062"</u>
Voltage	24-26	26-28
Amperage	120 - 150	180 - 250
Optimum	26 - 140	28 - 200
Stick-Out	1" - 2"	1½" - 2½"

- DC reversed polarity, 28-30 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" (for larger diameters)

TYPICAL APPLICATIONS:

- crusher parts & cones, swing hammers, crusher mantles, dragline buckets and lips, 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



