

HA - 3 - MX 9

OPEN-ARC FLUX-CORED HARDFACING WIRE

CHARACTERISTICS:

- medium alloy **martensitic steel**;
- deposit typically **relief checks** while offering **good abrasion resistance** and **moderate impact** capacity;
- multiple layer hardfacing wire although not recommended in very high impact applications;
- deposit is grindable only although it can be partially machined;
- hardfacing mild steel, low alloy steel and manganese steel;
- can be used as a final layer over HA-1, HA-2 & Macro series of rebuilding wires.

MECHANICAL PROPERTIES:

- 43 - 48 RC as deposited
- work hardens to 50 - 55 RC

<u>PROCEDURE:</u>	<u>.045"</u>	<u>.062"</u>	<u>Large</u>
Voltage :	26 - 30	26 - 30	28 - 34
Amperage :	120-160	210-275	250-400
Optimum	28 - 150	28 - 230	30 - 350
Stick-Out	1" - 2"	1½"-2½"	2" - 3"

- DC reversed polarity;
- remove all damaged material;
- avoid localized overheating of manganese steel by keeping bulk of part below 550°F;
- avoid thermal shock;

TYPICAL APPLICATIONS:

- grouser plates, dozer blades, dredge buckets, cutter heads, **mixer paddles**, road graders, grouser plates, conveyor screws, **cone crusher liners**, etc.

OTHER:

- Deposition Rate: 10 - 20 lbs./hr.;
- available in diameters of 7/64", 3/32", 5/64", 1/16" & .045";
- packaging: 28 & 10 lb. spools, 55 lbs. coils, 100, 250 & 500 lbs. pay-off-packs

