

HA - 4 - MO-HC

OPEN-ARC FLUX-CORED HARDFACING WIRE

CHARACTERISTICS:

- chromium carbides in a complex iron matrix;
- excellent abrasion resistance to both coarse and/or fine particles;
- moderate impact strength;
- deposit resistant to **heat, corrosion, and high velocity erosion;**
- best results with limit of two layers;
- deposit grindable only;
- hardfaces mild steel, low alloy steel and manganese steel;
- an excellent final overlay to use over the HA-2 and/or MACRO series of rebuilding wires.

MECHANICAL PROPERTIES:

- 57 - 61 RC as deposited

PROCEDURE:

- DC reversed polarity, 27-34 Volts, 250-400 Amps.;
- remove all damaged material;
- avoid localized overheating of manganese steel by keeping bulk of part below 550°F;
- avoid thermal choc;
- stick-out: 2 - 3"

TYPICAL APPLICATIONS:

- cone crushers, crusher parts, digger teeth, catalyst piping, tool joints, crusher hammers, ore chutes, bucket lips, etc.

OTHER:

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