

## HA - 4 - X C R

OPEN-ARC FLUX-CORED **HARDFACING** WIRE

### CHARACTERISTICS:

- an **enriched austenitic chromium carbide** steel which readily relief checks;
- **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;
- hardfacing 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:

- 58 - 62 RC as deposited

### PROCEDURE:

	<u>.045"</u>	<u>.062"</u>
Voltage	26 - 30	26 - 30
Amperage	120 - 160	210 - 275
Optimum	28 - 150	28 - 230
Stick-out	1" - 2"	1½" - 2½"

- 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:

- 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 1/16" & .045";
- packaging: 28lb. & 10 lb. spools., 55 lb. coils.

