

HA - 4

OPEN-ARC FLUX-CORED HARDFACING WIRE

CHARACTERISTICS:

- austenitic chromium steel;
- resists heavy impact and high abrasion;
- particularly enduring to abrasion of large particles;
- commonly called a **high chrome - high carbon wire**;
- 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 & MACRO series rebuilding wires.

MECHANICAL PROPERTIES:

- 55 - 60 RC as deposited

PROCEDURE:

- DC reversed polarity, 25-35 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:

- crusher parts, digger teeth, rod mill plates, grizzlies, ore chutes, bucket lips, swing hammers, etc.

OTHER:

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

