

HA - 5 0

OPEN-ARC FLUX-CORED REBUILDING WIRE

Characteristics:

- low alloy steel;
- offers good structural strength and impact resistance;
- moderate abrasion resistance;
- **can be multi-layered;**
- deposit is machinable and **can be flame cut;**
- excellent base for martensitic hardfacing material such as HA-3-MX4 and HA-60;
- welds with or without gas shielding;
- not recommended for manganese steel.

Mechanical Properties:

- 20 - 25 RC as deposited;
- 40 - 45 RC work hardened.

Procedure:

	<u>.045"</u>	<u>.062"</u>
Voltage	24 - 26	26 - 28
Amperage	110-150	175-250
Optimum	24 - 130	26 - 180
Stick-Out	1" - 2"	12" - 22"

- 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:

- power shovel parts, tractor joints, tractor drive components.

Other:

- deposition rate: 8 - 15 lbs./hr.;
- available in diameters of 1/16" and .045";
- packaging: 10 lb. and 28 lb. spools, 55 lb. coils

