

## HA - 5

### OPEN-ARC FLUX-CORED HARDFACING WIRE

#### CHARACTERISTICS:

- austenitic chromium carbide steel;
- outstanding combination of abrasion resistance and very heavy impact resistance;
- 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:

- 58 - 62 RC as deposited

#### PROCEDURE:

- DC reversed polarity, 24 -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 shock;
- stick-out: 2 - 3"

#### TYPICAL APPLICATIONS:

- muller wheels, dredge buckets, rod and ball mill liners, grizzlies, dragline bucket and lips, augers, etc.

#### OTHER:

- Deposition Rate: 10 - 20 lbs./hr.;
- available in diameters of 7/64", 3/32" & 5/64";
- packaging: 28 lb. spools, 55 lb. coils, 100, 250, & 450 lbs. pay-off packs.

