

HA - 5

HARDFACING STICK ELECTRODE

CHARACTERISTICS:

- austenitic chromium carbide steel;
- outstanding combination of abrasion resistance and heavy impact resistance;
- 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 MACROMANG rebuilding sticks.

MECHANICAL PROPERTIES:

- 60 - 63 RC as deposited

PROCEDURE:

- DC reversed polarity, 3/16" - 160 to 190 amps, 5/32" - 130 to 155 amps, 1/8" - 90 to 120 amps.;
- remove all damaged material;
- avoid localized overheating of manganese steel by keeping bulk of part below 550°F;
- avoid thermal shock;

TYPICAL APPLICATIONS:

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

OTHER:

- available in diameters of 3/16" (5.0 mm), 5/32", (4.0 mm) and 1/8" (3.2 mm);
- packaging: 10 lb. (4.5 kg.) boxes.

