

HA – 6 - CR

OPEN-ARC FLUX-CORED HARDFACING WIRE

CHARACTERISTICS:

- martensitic chromium carbide steel;
- 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 rebuilding wires.

MECHANICAL PROPERTIES:

- 56 - 61 RC as deposited

PROCEDURE:

	<u>5/64"</u>	<u>Large"</u>
Voltage	26 - 30	28 - 32
Amperage	250 - 300	275 - 400
Optimum	28 - 275	28 - 350
Stick-out	1 ½ " - 2 ½ "	2" - 3"

- DC reversed polarity;
- remove all damaged material;
- avoid localised overheating of manganese steel by keeping bulk of part below 550°F;
- avoid thermal shock;

TYPICAL APPLICATIONS:

- cone crushers, catalyst piping, tool joints, crusher hammers, dragline chains, grizzlies, ore chutes, augers, pug mill, paddles, 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 lb. pay-off-packs.

