

HA - 64

OPEN-ARC FLUX-CORED HARDFACING WIRE

CHARACTERISTICS:

- medium alloy **martensitic steel** containing carbon, molybdenum, boron & vanadium;
- offers **good abrasion resistance** and **moderate impact** capacity;
- 2 layers are recommended for maximum wear efficiency;
- **slag free deposit will relief check** and is grindable only;
- hardfaces mild steel, low alloy steel and manganese steel;
- can be used as a final layer over HA-1, HA-2 or MACRO series of rebuilding wires.

MECHANICAL PROPERTIES:

- 58 - 65 RC as deposited

<u>PROCEDURE:</u>	<u>.045"</u>	<u>.062"</u>	<u>Large</u>
Voltage :	26 – 28	26 – 30	28 - 34
Amperage :	120-160	250-300	275-400
Optimum	28 – 150	28 – 275	30 - 350
Stick-Out	1" - 2"	1½-2½	2" - 3"

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

TYPICAL APPLICATIONS:

- grouser plates, dozer blades, dredge buckets, cutter heads, **mixer paddles**, road graders, grouser plates, conveyor screws, **cone crushers liners**, etc.

OTHER:

- Deposition Rate: 10 - 20 lbs./hr.;
- available in diameters of 7/64", 3/32", 5/64", 1/16" & .045";
- packaging: 10 & 28 lb. spools, 55 lbs. coils, 100, 250 & 450 lb. pay-off-packs

