

HA - 6 - XCR - HARDFACING STICK ELECTRODE

CHARACTERISTICS:

- **tubular stick electrode** for **out of position** welding;
- **martensitic chromium carbide** steel;
- excellent abrasion resistance to both coarse and/or fine particles;
- very good impact strength;
- 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:

- 62 - 64 RC as deposited

PROCEDURE:

- DC reversed polarity,
- 7/16" - 210 to 250 amps, 5/16" - 190 to 220 amps, 1/4" - 100 to 140 amps.;
- 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:

- available in diameters of 7/16", 5/16", and 1/4";
- packaging: 11 lb.(4.5 kg.) boxes.