

## HA - 7 - HC

### OPEN-ARC FLUX-CORED **HARDFACING** WIRE

#### CHARACTERISTICS:

- an **enriched martensitic chromium carbide** steel;
- excellent abrasion resistance to fine and/or wet particles;
- moderate impact strength;
- best results with limit of two layers;
- deposit grindable only;
- hardfaces mild steel, low alloy steel and manganese steel;
- operation temperatures up to 900° F;
- an excellent final overlay to use over the HA-2 and/or MACRO series rebuilding wires.

#### MECHANICAL PROPERTIES:

- 68 - 70 RC as deposited

#### PROCEDURE:

	<u>.045"</u>	<u>.062"</u>
Voltage	26 – 30	26 – 30
Amperage	120 – 160	210 – 275
Optimum	28 – 150	28 – 230
Stick-out	1" – 2"	1 ½" - 2 ½"

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

#### TYPICAL APPLICATIONS:

- scraper blades, ditcher teeth, ripper shanks, dredge parts, sand chutes, coke crusher segments, exhaust fans, rake teeth in furnaces, slag ladles, etc.

#### OTHER:

- Deposition Rate: 8 - 15 lbs./hr.;
- available in diameters of 1/16" & .045";
- packaging: 10 & 28 lb. spools, 55 lb. Coils.

