

## HA - 7

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

#### CHARACTERISTICS:

- 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:

- 59 - 63 RC as deposited

#### PROCEDURE:

|           | <u>.045"</u> | <u>.062"</u> | <u>Large</u> |
|-----------|--------------|--------------|--------------|
| Voltage   | 26 – 30      | 26 – 30      | 28 – 34      |
| Amperage  | 120 – 160    | 210 – 275    | 275 – 400    |
| Optimum   | 28 – 150     | 28 – 230     | 28 – 350     |
| Stick-out | 1" – 2"      | 1 ½" - 2 ½"  | 2" – 3"      |

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

