FILOTECH
Electrodes inc.

H A C - 7 - M N

OPEN-ARC FLUX-CORED **REBUILDING & REPAIR** WIRE

Characteristics

- open arc flux-cored welding wire;
- **austenitic heat-resisting steel**;
- often used to weld alloys of similar composition (300 class) as well as other **heat treated wear plates;**
- **resists corrosion, erosion, and oxidation**;
- used in applications requiring heat resistance up to 1500°F;
- deposit is highly crack resistant and slightly workhardening;
- not affected by heat treatment;
- costly gas shielding and/or cumbersome fluxing agents are **not required**;
- **easily removable slag** reveals a smooth slightly convex bead of shiny stainless steel;

Mechanical Properties

- Yield: 70,000 psi. min.
- Tensile: 100,000 psi. min.
- Elongation in 2": 40 - 45% min.

Procedures	.045"	.062"	Large Diameters
Voltage	24 – 32	26 – 28	28 – 32
Amperage	100-190	200 – 275	280 – 375
Optimum	28 – 140	28 – 225	30 – 350
Stick-out	1" – 2"	1½" - 2½"	2" - 3"

- DC reversed polarity
- remove all damaged materials on surface to be welded
- preheat to 300 - 400°F
- avoid thermal shock
- peening between passes is recommended to relieve local stress;

Applications

- railway car wheels, dies, tools, non-magnetic chrome-nickel steels, chrome-steels, heat resistant steels, etc.

Other

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

ENREGISTRÉ BNQ ISO 9002 REGISTERED

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