

H A C - 7 - M N

STICK-ELECTRODE FOR REPAIRS

CHARACTERISTICS:

- a very distinct electrode used for joining and rebuilding different types of steel with excellent mechanical properties;
- material deposited resists cracking, corrosion and high impact even on high alloy steel, carbon steel, manganese, and unknown alloyed steel;
- very smooth flowing characteristics;
- multi-pass capabilities;
- excellent cushion layer for hardfacing alloys;

MECHANICAL PROPERTIES:

- Tensile : 100,000 psi.
- Yield : 87,000 psi.
- Elongation : 39 to 44%
- Hardness as deposited : 19 to 22 RC
- Hardness work hardened : 48 to 54 RC

PROCEDURE:

- DC reversed polarity, 3/16" - 140 to 190 amps, 5/32" - 95 to 150 amps, 1/8" - 75 to 125 amps.;
- remove all damaged material;
- gouge thick sections if necessary with HA-92 gouging rod;
- preheat to 400 ° F for high alloy steels;
- using a stringer bead technique, allow each pass to cool before removing slag;
- in order to reduce local stress, peen each welded pass;
- avoid thermal shock;

TYPICAL APPLICATIONS:

- crusher parts, wobblers, runners, impellers, conveyor chains, wheel excavator teeth, crusher jaws, muller tires, rebuilding of shafts, axels and heavy machinery repairs, etc.

OTHER:

- available in diameters of 3/16", 5/32", and 1/8";
- packaging: 10 lb. (4.5kg.) boxes.

