FILOTECH
Electrodes inc.

HA-12

Open-arc flux cored wire and stick electrodes

CHARACTERISTICS:

- iron based martensitic alloy;
- weld metal composition and physical properties similar to those of H-12 modified tool steel;
- used to surface mild and low alloy steel components subject to moderate abrasion and/or high temperature (1000° F);
- proper preheat is required for crack-free deposits;
- deposit can be machined using carbide tools only;
- best results with limit of three layers;
- deposit is covered by a thin-easily removed layer of slag which can be either welded over and/or brushed off;
- wire can be welded with or without gas shielding;

MECHANICAL PROPERTIES:

- 49 - 56 RC as deposited

PROCEDURE:

- DC reversed polarity, 26-32 Volts, 225-350 Amps.;
- remove all damaged material;
- preheat to 300 to 500° F;
- avoid thermal choc;
- stick-out: 1 ½ - 2"

TYPICAL APPLICATIONS:

- machine components, tools, sliding metal part, cable sheaves, hot and cold shear blades, crane wheels, forging dies, etc.

OTHER:

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

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ENREGISTRÉ BNQ ISO 9002 REGISTERED