

HABCO HF 960

**MULTI-LAYER HARD SURFACING ELECTRODE FOR HIGH ABRASION
COUPLED WITH MEDIUM TO HEAVY IMPACT**

FEATURES

HABCO HF 960 is a general purpose, hard surfacing alloy for surfaces subjected to abrasive wear and impact. The deposits are crack resistant and can be forged. Heavy build-ups are possible without the need for softer cushion layers. **Excellent for out-of-position field welding applications.**

APPLICATIONS

For build-up and surfacing of new and worn machine parts of steel, cast steel, manganese steel and cast iron. Also for dredger teeth, crusher jaws, hammer mill parts, conveyors, pressure rollers, shovel teeth, stampers, caterpillar drives, earth boring equipment and railroad maintenance equipment. Used in the agricultural, construction and mining industries.

INSTRUCTIONS

Remove all foreign material from weld area. Preheat is not necessary. Maintain a medium arc length making either stringer or weave beads. Allow parts to cool slowly.

Hardness: 52-60 RC

Current: AC or DC \pm

Amperage:	80-120	110-160	140-180	175-220
Diameters: (in)	1/8	5/32	3/16	1/4
(mm)	3.25	4.0	5.0	6.0

• Available in WIRE form