

# HABCO HF 962

**LOW TEMPERATURE HIGH ALLOYED HARDFACING ELECTRODE FOR MEDIUM IMPACT, HIGH ABRASION AND COMPRESSION RESISTANCE**

## FEATURES

This electrode offers optimum efficiency at low amperage settings, minimizing dilution of the highly alloyed weld metal. Extra high deposition rates and easy slag removal make this product a favorite for a wide variety of surfacing jobs on manganese, carbon, and alloy steels, as well as cast iron.

## APPLICATIONS

**HABCO HF 962** was developed for use on earth moving equipment, crusher jaws, drilling tools, hammers, concrete paddles, buckets and asphalt ripper teeth, farm implements and other equipment subject to severe abrasion and impact at either normal or elevated temperatures. Weld deposits will cross check to relieve stress.

## INSTRUCTIONS

Remove all foreign material and unsound metal from surfaces to be welded. Keep electrode vertical to work piece and maintain a short arc length. Adjusting arc lengths will allow the welder to surface all different thicknesses of base materials without warpage or distortion. Deposits must be kept thin. Maximum of 2-3 layers is recommended.

**Hardness (as welded): 58-62 RC**

**Metal Recovery: 140%**

**Current: AC or DC  $\pm$  (Use straight polarity for thin deposits)**

<b>Amperage:</b>	<b>50-80</b>	<b>90-130</b>	<b>100-150</b>	<b>140-190</b>
<b>Diameters: (in)</b>	<b>3/32</b>	<b>1/8</b>	<b>5/32</b>	<b>3/16</b>
<b>(mm)</b>	<b>2.5</b>	<b>3.25</b>	<b>4.0</b>	<b>5.0</b>

• Available in WIRE form