

HABCO MT 996 (S)

A TUBULAR SPRAY FUSION TRANSFER, HARDFACING ELECTRODE, WITH SUPER HARD DEPOSITS FOR EXTREME ABRASION AND GOOD IMPACT RESISTANCE

FEATURES

Due to the unique spray fusion transfer deposit feature of METAL TUBE 996 and the minimum dilution in base metal, full hardness can be obtained with two layers. METAL TUBE 996 has a low amperage requirement, which allows this alloy to be used with ALL WELDING MACHINES. Low amperage operation virtually eliminates the problems associated with over heating of manganese steels. No cushion layer is required for deposits on low carbon, gray cast and austenitic manganese steels.

APPLICATIONS

Wherever severe abrasion is encountered such as, dredge bucket lips, crusher jaws, mantles and liners, swing hammers, screen plates, grizzly bars, shovel buckets, railway ballast sleds, undercutter chains, and tampers.

INSTRUCTIONS

Remove unsound base metal using **HABCO MX 222**. Deposit alloy using a moderately long arc length and a slow weave bead. Two layer deposit maximum. Cross-checking will occur as the deposit relieves itself of internal stress. For out-of position welding, weld down-hand, or at a slight up-hand angle for heavier build-up.

Alloy Content: Cb Cr C Mn Vn Mo W

Hardness: 62 - 64 RC / CARBIDE VICKERS 1950

Current: AC or DC ±

Amperage:	50-80	130-190	195-426
Diameters: (in)	1/4	3/8	1/2
(mm)	6.0	9.0	12.0