

HABCO FROGSEAL® (S)

MICRO DENSE COATED ELECTRODE FOR REPAIRING, JOINING AND SURFACING COMPONENTS SUBJECT TO HIGH IMPACT

FEATURES

HABCO FROGSEAL®, has a high deposition rate, and produces smooth, non-cracking welds with an outstanding resistance to heavy impact.

APPLICATIONS

HABCO FROGSEAL®, is ideal for repairing or "sealing" cracks and surfacing damaged manganese parts such as rail frogs and switchpoints. Often used as a cushion layer or "butter pass" prior to applying **HABCO FROGSPEC®**, . The deposit is not affected by heat treatment and is an excellent choice for the repair and build-up of tools, dies, non-magnetic chrome and heat resistant steels. **FROGSEAL®**, is also used for joining of high to low alloyed steels and for surfacing manganese steels, crusher hammers, rolls and mantles.

INSTRUCTIONS

Remove hardened or unsound surface material using **HABCO AIR GOUGING CARBONS** or **HABCO MX 221**. **DO NOT PREHEAT**. Prevent excessive heat build-up on the work piece by maintaining a short arc, particularly on manganese steels. Allow part to cool slowly.

Tensile Strength: up to 110,000 Psi (77 kg/mm²)

Yield Strength: up to 68,000 Psi (48 kg/mm²)

Elongation: 40%

Hardness: as welded: up to 160 BNH

Work Hardens: up to 450 BNH

Current: AC or DC ±

Amperage:	90-130	120-160	140-190
Diameters: (in)	1/8	5/32	3/16
(mm)	3.25	4.0	5.0

- Available in **WIRE** form