

HABCO RAILSPEC® (S)

**SPECIALLY FORMULATED MICRO DENSE COATED ELECTRODE
FOR BUILD-UP ON MOST STEELS - MACHINEABLE**

FEATURES

HABCO RAILSPEC®, deposits are tough, medium hard and machinable. The deposits can be flame cut, or can be forged. Ideal as an underlay prior to hardfacing overlays, or where rapid build-up is required. **120% metal recovery rate.**

APPLICATIONS

Build-up on carbon steel frogs, rail ends, tractor pads and rollers: surfacing of structural steel or cast steel machine components subject to wear, such as slide ways, truck wheels, wheel crowns, guides, couplings, brake drums and rope winches.

INSTRUCTIONS

Clean and prepare weld zone using **HABCO MX 221** or grinder. If high build-up is desired, use DC straight polarity. The deposit should be made in stringer beads, or with a weaving technique. **HABCO RAILSPEC®**, deposits well in all positions with low spatter. Deposits can be forged at medium heat.

Hardness: 310-400 HB

Current: AC or DC ±

Amperage:	110-140	130-180	170-220	180-240
Diameters: (in)	1/8	5/32	3/16	1/4
(mm)	3.25	4.0	5.0	6.0

• Available in **WIRE** form