

HABCO SX 554

ULTRA STRENGTH HIGH ALLOY ELECTRODE WITH MICRO-DENSE COATING FOR ALL STEELS

FEATURES

An ultra high strength electrode with high corrosion, crack and heat resistance. It can be easily welded in all positions. High strength welds are achieved while maintaining ductility. The fully machinable deposits have no hard spots.

APPLICATIONS

HABCO SX 554 is for the maintenance welder who does not know the type of steel they are welding, or must weld dissimilar steels. Commonly used for repairing tools, dies, carbon steels, spring steels, and stainless steels. Ideal for welding low, medium and high alloy steels where high strength is essential. Use as an overlay cushion prior to hardfacing.

INSTRUCTIONS

Prepare joining area by removing foreign material. Use **HABCO MX 222** to bevel heavy sections. Hold a short arc, or use drag technique, use stringer beads. For high alloys and heavy sections, preheat to 400°F (204°C), skip weld and peen lightly to avoid internal stress.

Tensile Strength: 126,000 Psi (89 kg/mm²)

Work Hardens: 90,000 Psi (63 kg/mm²)

Elongation: up to 35 %

Hardness: up to 230 BH as deposited / Up to 500 BH work hardened

Current: AC or DC +

Amperage:	30-40	40-70	60-90	75-125	95-125	150-240
Diameters: (in)	1/16	5/64	3/32	1/8	5/32	3/16
(mm)	1.6	2.5	2.5	3.25	4.0	5.0