

HABCO SX 555 TIG

**THE STRONGEST PROBLEM SOLVING UNIVERSAL
TIG ELECTRODE FOR ALL STEELS**

FEATURES

HABCO SX 555 TIG is a premium TIG electrode that provides dense, porosity and spatter free deposits that are strong and crack resistant.

APPLICATIONS

Welding low, medium and high alloy steels requiring the highest strength and quality. Ideal for repair of tools, dies, springs, carbon steels, stainless steels, pressure vessels, vanadium-moly spring steels and as an underlayment or pad prior to applying hardfacing alloys. Also used for re-building shafts and blades used in the chemical, construction and mining industries.

INSTRUCTIONS

Prepare joint area by removing foreign material. Bevel heavy sections to form a 90° vee. Preheat high carbon steels to 400°F (204°C). Use jigs, fixtures and tack welds to maintain alignment. Hold short arc. Stringer beads are preferred to prevent overheating. Allow to cool before removing slag. Deposits will take a high polish when subjected to wear.

Tensile Strength: up to 125,000 Psi (88 kg/mm²)

Work Hardens: up to 180,000 Psi (127 kg/mm²)

Elongation: up to 35%

Heat Resistance: 1400°F (760°C) - 1600°F (871°C)

Diameters:

(in)	0.035	0.045	1/16	3/32	1/8
(mm)	0.9	1.2	1.6	2.5	3.25

- Available in (GMAW) MIG form