

# HABCO HP 10

**A DUCTILE, EASILY MACHINED NICKEL ALLOY FOR BUILD-UP AND JOINING OF MOST CAST IRONS AND STEEL**

## FEATURES

**HABCO HP 10** is a soft, ductile, nickel boron alloyed spray powder containing other special elements. It has a particle size to enhance its bonding capability to grades of cast iron. It has excellent resistance to impact. The color match is excellent to most cast irons and steels.

## APPLICATIONS

The excellent wettability and low diffusion bonding temperatures for use on common grades of cast iron. It is used for cladding and joining cast iron to steel. Excellent ductility makes it ideal as a build-up type alloy prior to putting on harder Hotspray alloys.

## PROCEDURE

The area to be overlaid should be cleaned just before applying. Pre-heat the entire area to 600°F (315°C) (on steel, a blue tint will be noticed). Spray a thin layer of powder over the entire area keeping the torch tip approximately 2-3 inches from the work piece. Without spraying any more alloy, position the tip about 3/4 inch to 1 inch above the work piece and wet the alloy out. If a thicker deposit required, repeat the process.

**Tensile Strength: up to 76,000 Psi (53 kg/mm<sup>2</sup>)**

**Hardness: RC 14-17**