

HABCO HP 20

**SOFT, TOUGH, BUILD-UP AND JOINING ALLOY
FOR MOST FERROUS ALLOYS**

FEATURES

HABCO HP 20 is a tough, easily machined nickel base alloy spray powder. The controlled plastic range of this alloy makes it ideal for build-up applications steel and nickel alloys. The deposits are extremely dense and easily machined to a fine surface finish.

PROCEDURE

The area to be overlaid should be cleaned just before applying. Pre-heat the entire area to 600°F (315°F) (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 workpiece and wet the alloy out. If a thicker deposit required, repeat the process.

TECHNICAL DATA

HABCO HP 20 is a high nickel alloy that has a plastic range designed for easy build-ups. It has excellent corrosion resistance and impact qualities. Suitable for use steels, stainless steels, nickels and cast iron.

Hardness: RC 18-22