

# HABCO HP 30

**A DENSE, TOUGH, SEMI-HARD MACHINABLE ALLOY  
FOR REBUILDING WORN PARTS**

## FEATURES

**HABCO HP 30** is a nickel chromium-bearing alloy that combines good machinability with good wear qualities. The deposits are extremely tough and will withstand severe impact. The dense deposit of **HP 30** gives it a good, low coefficient of friction. This versatile alloy has excellent weldability with good build-up qualities and machinability.

## APPLICATIONS

The combined qualities of toughness, friction, abrasion and impact resistance makes it ideal for heavier build-ups that require after machining. Used for tooth build-ups, or shaft repairs, including worn keyways. Often used as a medium hard-facing alloy, especially where corrosion may be a factor. It can be used on all ferrous and nickel base alloys.

## PROCEDURE

The area to be overlayed should be cleaned just before applying. Pre-heat the entire area to 600°F (316°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 workpiece and wet the alloy out. If a thicker deposit required, repeat the process.

## TECHNICAL DATA

**HABCO HP 30** is a high nickel chromium alloy. The high alloy chemistry and Density of deposit enhance its corrosion resistance and machinability. The synergistic elements in the alloy chemistry give it superior wetting capability on most metals.

**Hardness: RC 37-40**