

HABCO ST 560

UNIVERSAL ELECTRODE FOR HIGH TEMPERATURE AND CORROSION RESISTANT WELDS

FEATURES

HABCO ST 560 features a high alloy content that produces deposits that are heat resistant up to 2400°F (1316°C). Good weldability in all positions, smooth beads, almost no spatter and easy slag removal make this electrode very popular for both, production and maintenance applications.

APPLICATIONS

Cladding and joining of steels subjected to elevated temperatures such as furnace parts, heat treating boxes, ladels, crucibles, heating plates, high temperature fan blades, tanks and grates.

INSTRUCTIONS

Prepare weld zone according to standard welding practice. Bevel heavy sections to form a 75° vee. Preheat is not required. Maintain a short arc. Stringer beads are recommended followed with peening to reduce stresses. Do not permit temperature of base metal to exceed 400°F (200°C). Avoid undercutting and deep penetration. Remove slag between passes.

Tensile Strength: up to 105,000 Psi (75 kg/mm²)

Yield Strength: up to 68,000 Psi (49 kg/mm²)

Elongation: approx. 40%

Hardness: 200 HB

Heat Resistance: up to 2400°F (1316°C)

Current: AC or DC +

Amperage:	50-80	70-110	90-150
Diameters: (in)	3/32	1/8	5/32
(mm)	2.5	3.25	4.0

• Available in (GTAW) TIG and (GMAW) MIG form