

HABCO ST 570

MICRO DENSE COATED CORROSION RESISTANT STAINLESS STEEL ALLOY. HIGH DEPOSITION RATE

FEATURES

HABCO ST 570 is a high speed, high deposition rate alloyed electrode designed to produce weld deposits that are extremely resistant to pitting in corrosive environments. The addition of molybdenum in this alloy along with its controlled carbon content make this electrode a perfect choice for use as an overlaying alloy used in corrosive situations.

APPLICATIONS

Common uses of this electrode include use in the paper, pulp, textile, petroleum and chemical industries. Large quantities of this alloy are used to protect surfaces from various highly corrosive media. This electrode is your first choice when protecting against corrosion. Excellent for welding stainless steels: 316, 316L, 328, 303, 315 and 329.

INSTRUCTIONS

Clean and prepare weld zone in accordance with standard welding practice. Do not preheat base metal. Tack parts to maintain alignment and reduce distortion. Maintain a short or drag type arc length. Prevent excessive heat build-up by skip welding whenever possible. Remove slag between passes and allow slow cool.

Tensile Strength: up to 105,000 Psi (74 kg/mm²)

Yield Strength: up to 62,000 Psi (44 kg/mm²)

Elongation: 40%

Current: AC or DC +

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|------------------------|--------------|---------------|----------------|----------------|----------------|
| Amperage: | 35-65 | 90-110 | 110-160 | 150-190 | 160-200 |
| Diameters: (in) | 5/64 | 3/32 | 1/8 | 5/32 | 3/16 |
| (mm) | 2.0 | 2.5 | 3.25 | 4.0 | 5.0 |