

# HABCO ST 576

**OUTSTANDING HEAT AND CORROSION RESISTANT  
ALLOY ELECTRODE FOR JOINING AND BUILD-UP  
ON HIGH ALLOY MATERIALS**

## FEATURES

**HABCO ST576** has outstanding alloying characteristics providing **x-ray quality welds in all positions** on a wide variety of high nickel and steel alloys. Deposits resist oxidizing and non-oxidizing salts, alkalis and organic acids. Deposits resist corrosion to vapors and solutions of sulphuric and hydrochloric acids as well as chlorine gas and hydrochlorites.

**HABCO ST 576** also resists pitting in sea water and marine environments.

## APPLICATIONS

Typical applications include hot forging dies, ladles, tong bits, forming rolls, draw punches and any parts exposed to extreme thermal shock, heavy corrosion, oxidation or heavy impact. Some specific corrosion applications include chlorine equipment, hot brine pumps, ethyl sulphate absorbers, flare stack eductors and equipment exposed to halogen bearing plastics.

## INSTRUCTIONS

Base metal must be clean. Remove all damaged metal. Use short arc and stringer beads. For best results limit deposit to two passes, and preheat heavy or critical sections to 600°F (315°C). Fill all craters. Heat treating is not recommended unless metal is subjected to below freezing temperature.

**Tensile Strength: up to 100,000 Psi (70 kg/mm<sup>2</sup>)**

**Current: AC or DC +**

|                        |              |               |               |
|------------------------|--------------|---------------|---------------|
| <b>Amperage</b>        | <b>50-80</b> | <b>70-110</b> | <b>90-135</b> |
| <b>Diameters: (in)</b> | <b>3/32</b>  | <b>1/8</b>    | <b>5/32</b>   |
| <b>(mm)</b>            | <b>2.5</b>   | <b>3.25</b>   | <b>4.0</b>    |