

HABCO SA 334 (S)

A MICRO DENSE COATED HIGH STRENGTH ELECTRODE FOR WELDING OF LOW TO MEDIUM CARBON AND LOW ALLOYED STEELS

FEATURES

HABCO SA 334 has a specially formulated **micro-dense coating providing superior moisture resistance** which produces dense, porosity free welds in all operating positions. Its exceptional elongation and ductility coupled with a very high tensile strength make it the ideal electrode for critical repair welds on heavy equipment. Weld deposits are X-ray quality and crack free. **Metal recovery of 120%.**

APPLICATIONS

For joining and build-up of high strength quench and tempered steels such as T1, Jallo, HY 80, HY 90, and HY 100. **Commonly used for repair welds on all types of construction, mining and earth moving equipment.**

INSTRUCTIONS

Clean and prepare weld zone in accordance with standard welding practice. No preheat is necessary when an ambient temperature is above 50°F (8°C). Heavy sections should be preheated between 400°- 600°F (200°- 300°C). Run stringer beads while maintaining a short arc length. To stress relieve, heat to 1025°F (550°C) and maintain for one hour.

Tensile Strength: up to 120,000 Psi (84 kg/mm²)

Yield Strength: up to 98,000 Psi (69 kg/mm²)

Elongation: up to 24%

Current: AC or DC ±

Amperage:	70-110	100-140	125-190	180-150
Diameters: (in)	3/32	1/8	5/32	3/16
(mm)	2.5	3.25	4.0	5.0

• Available in **WIRE** form