

HABCO TX 964HW

**UNIQUE ELECTRODE FOR HOT AND COLD WORKING
TOOL STEELS**

FEATURES

The unique formulation of the **HABCO TX 964HW** was developed to produce a hard tough and heat resistant deposit that is ideal for rebuilding cutting edges and abraded surfaces which are exposed to extreme temperatures.

APPLICATIONS

Hardfacing of hot and cold shear blades, deep drawing dies, forming dies, punching tools and hot cold trimming tools. Excellent for tool steels such as SKD-12 (A-2), SKD-4 (H-14) and SKD-61 (H-13) Chemical composition closely matches the tool steel welding requirements of SKD-1(D3) , SKD-11 (D2).

INSTRUCTIONS

Prepare weld zone in accordance with standard welding procedure. Use **HABCO SX 555 PLUS** as a cushion layer. Preheat tool to 500°F (260°C). Apply weld deposit in short stringer beads. After welding, allow part to cool slowly while packed in dry sand. Heat-treat part according to manufacturers recommendations. Low amperages should be used on both AC and DC to reduce heat input and base metal dilution. Second layer hardness of 57-59 RC is obtained without post weld heat treatment.

Hardness (deposited): 57-59RC

Tensile Strength: 112,000 Psi (79 kg/mm²)

Current: AC or DC ±

Amperage:	60-90	60-120	80-160	130-180
Diameters: (in)	3/32	1/8	5/32	3/16
(mm)	2.5	3.25	4.0	5.0

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