

HABCO FROGSPEC[®]-0 **F**

HIGH NICKEL, CHROME-MANGANESE FOR BUILD-UP AND JOINING - FLUX-CORED OPEN ARC WIRE — SELF-SHIELDING

FEATURES

This product is renowned for being amongst the toughest and most impact resistant of alloyed wires currently available. Due to its high alloy content, the need for further hardfacing alloys is often eliminated. With its outstanding ability to work harden under load, **HABCO FROGSPEC[®]-0** is the choice for build-up and joining of all 11% - 14% manganese steels, as well as carbon steels, and other alloyed steels. Multi-layered deposits remain machinable prior to work hardening. **FROGSPEC[®]-0** produces high yield strength deposits extremely resistant to deformation or mushrooming of the deposit.

APPLICATIONS

Formulated for high impact environments such as rail frogs, switch points, crusher cones/rolls, hammers, grousers and bucket teeth, or most applications where manganese steels are used. **HABCO FROGSPEC[®]-0** is also an excellent base for harder wearfacing alloys.

INSTRUCTIONS

Clean and prepare weld zone using HABCO AIR GOUGING CARBONS or **HABCO MX 221**.

- Avoid overheating of manganese steel, keeping bulk of part below 500°F (260°C).
- Use water-cooling method to keep manganese castings cool during welding process.
- Stick-out 2" – 3"
- Deposition rate: 10 – 20 lbs. per hour.

Tensile Strength: up to 130,000 Psi (91 kg/mm²)

Yield Strength: up to 92,000 Psi (65 kg/mm²)

Hardness as deposited: 200 BNH • Work Hardened: up to 470 BNH

Current: DC +

Diameters: (in)	7/64 & 3/32	5/64	1/16	.045
(mm)	2.8 & 2.5	2.0	1.6	1.2

RANGES:

Amperage:	275 - 425	250 - 325	210 - 275	120-150
Voltage:	30 - 35	28 - 32	26 - 30	28 - 30
Optimums:	350 / 32	275 / 30	240 / 28	140 / 28

PACKAGING: 10lb. & 28lb. Plastic Spools • 55 lb. Coils

• 100lb & 250lb. Pay-off Packs (7/64 & 3/32 ONLY)