

# HABCO RAILSPEC<sup>®</sup>-0 **F**

**RE-BUILDING WIRE FOR MEDIUM CARBON AND LOW ALLOY STEELS, FLUX CORED OPEN ARC – SELF SHIELDING**

## FEATURES

A low alloy, pearlitic steel offering excellent endurance to rolling loads with exceptional strength and impact resistance., along with moderate abrasion resistance. **HABCO RAILSPEC<sup>®</sup>-0** work hardens under load. Offering multi-layer capability in the rebuilding of mild and low alloy steels, deposits are machinable and can be flame cut. An excellent base for hardsurfacing. Easy slag removal. Not recommended for build up on manganese steel.

## APPLICATIONS

Build up on rails, rail ends, tractor pads, and rollers; hard facing of structural steel or cast steel machine components subject to wear, such as slide ways, truck wheels, wheel crowns, guides, couplings, brake drums, and rope winches.

## INSTRUCTIONS

- Avoid thermal shock.
- Stick-out: 2" - 3" (For 1/16" and .045" stick out should be 1 1/2")
- Deposition rate: 10 - 20 lbs per hour

**Hardness as deposited: 250 - 350 BHN; (work hardens) up to 450 BHN**  
**Current: DC +**

<b>Sizes: (in)</b>	<b>7/64 &amp; 3/32</b>	<b>5/64</b>	<b>1/16</b>	<b>.045</b>
<b>(mm)</b>	<b>2.8 &amp; 2.5</b>	<b>2.0</b>	<b>1.6</b>	<b>1.2</b>

### RANGES:

<b>Amperage:</b>	<b>250 - 350</b>	<b>225 - 275</b>	<b>110 - 120</b>	<b>100 - 110</b>
<b>Voltage:</b>	<b>28 - 30</b>	<b>26 - 30</b>	<b>26 - 28</b>	<b>26 - 28</b>
<b>Optimums:</b>	<b>330 / 28</b>	<b>250 / 28</b>	<b>110 / 26</b>	<b>100 / 26</b>

**PACKAGING: 10lb. & 28lb. Plastic Spools • 55 lb. Coils**  
**100lb & 250lb. Pay-off Packs (7/64' & 3/32" only)**