

HABCO HF 963

**PREMIUM HARDFACING ELECTRODE FOR SEVERE ABRASION
SMOOTH DEPOSIT – HIGH DEPOSITION RATE**

FEATURES

For use where a combination of hardness and toughness is desired on carbon, alloy steels, manganese and cast iron. **HABCO HF 963** provides good compressive strength and superior weldability. The high chromium content produces weld deposits, which maintain their resistance even at elevated temperatures.

APPLICATIONS

For parts subjected to severe abrasion but with light impact such as equipment for processing soil, rock, coal, cement, ceramic matter, grinding plates, dredge teeth, conveyor and press screws, coal augers, agitators, earth augers and scrapers. Also for surfaces that must resist abrasion combined with scaling such as open-hearth tools, grates, conveying chains in annealing furnaces and manipulators.

INSTRUCTIONS

Remove foreign material and unsound metal from surface to be welded. Keep electrode vertical to work piece and maintain a short arc. Deposits must be kept thin, never more than three layers thick. To prevent excessive local heat build-up in the part, alternate welding area. Allow part to cool slowly.

Hardness as deposited: 60-62 RC

Heat Resistance: up to 1000°F (538°C)

Current: AC or DC +

Amperage:	80-125	100-160	125-190
Diameters: (in)	1/8	5/32	3/16
(mm)	3.25	4.0	5.0

- Available in WIRE form