

# HABCO HX 965

## COMPLEX CARBIDE ELECTRODE FOR EXTREME ABRASION EVEN AT ELEVATED TEMPERATURES

### FEATURES

**HABCO HX 965** is a unique wearfacing alloy containing Chromium, Tungsten, Molybdenum, Columbium and Silicon, producing a multi-carbide deposit. This smooth running electrode features a deposition rate of 240%, to ensure economic welding. The deposits are highly resistant to abrasion and erosion, even at elevated temperatures, up to 1600°F (871°C). The arc is easily controlled, even on AC, with minimal slag.

### APPLICATIONS

Commonly used where abrasion, especially fine particle abrasion coupled with high temperature, creates serious wear problems. Surfaces worn by conveyed or moving cement, hot coke, gravel, sand, slag or coal, can be protected by this extremely hard wearfacing alloy.

### INSTRUCTIONS

Remove all foreign material from weld area using **HABCO MX 222**. Welding should be done in either flat or horizontal position. Crack sensitive material should be pre-heated to 750-930°F (400-500°C). Slag can be over-welded. Medium build-up is possible at a high current load. Do not deposit more than three layers on top of each other. In the case of thick hardfacings, cushion **HABCO FROGSEAL®** or **HABCO HF 960**, as an example.

**Hardness: 63–65 RC**

**Hot Hardness: up to 1600°F (871°C)**

**Current: AC or DC +**

<b>Amperage:</b>	<b>90-125</b>	<b>130-160</b>	<b>170-320</b>
<b>Diameters: (in)</b>	<b>1/8</b>	<b>5/32</b>	<b>3/16</b>
<b>(mm)</b>	<b>3.25</b>	<b>4.0</b>	<b>5.0</b>

• Available in WIRE form