

# HABCO SX 555 PLUS (S)

**SUPERIOR MICRO DENSE COATED, SUPER STRENGTH HIGH ALLOY STAINLESS STEEL, VANADIUM-MOLY ELECTRODE FOR WELDING ALL STEELS**  
**BROKEN STUD REMOVAL**



## FEATURES

**HABCO SX 555 PLUS** is a superior highly alloyed low temperature electrode for welding all types of steels. The deposits are highly resistant to heat and corrosion, and can be readily machined. Re-strike is excellent with virtually a self-releasing slag. Works well on low, open circuit voltage machines or AC buzz boxes.

## APPLICATIONS

Ideal for welding tool steels, dies and fixtures. Also for vanadium-moly steels, spring steels, nickel clad steels, pressure vessels, and turbine frames. Excellent choice for rebuilding shafts and blades used in the chemical, construction, and mining industries. **SX 555 PLUS** is also the welders' choice for joining stainless steels of unknown analysis. **Used for the removal of broken studs.**

## INSTRUCTIONS

Prepare joint area by removing foreign material. Bevel heavy sections to form a 90° vee. Preheat high carbon steels to 400°F (204°C). Use jigs, fixtures and tack welds to maintain alignment. Hold short arc. Stringer beads are preferred to prevent overheating. Allow to cool before removing slag. Deposits will take a high polish when subjected to wear.

**Tensile Strength: 130,000 Psi (98 kg/mm<sup>2</sup>)**

**Work Hardens: up to 250,000 Psi (176 kg/mm<sup>2</sup>)**

**Yield Strength: up to 90,000 Psi (63 kg/mm<sup>2</sup>)**

**Elongation: 35 %**

**Hardness: up to 300 HB as welded / work hardens to 450 HB**

**Heat Resistance: up to 1600°F (871°C)**

**Current: AC or DC +**

<b>Amperage:</b>	<b>30-40</b>	<b>35-65</b>	<b>40-80</b>	<b>65-120</b>	<b>90-150</b>	<b>140-220</b>
<b>Diameters: (in)</b>	<b>1/16</b>	<b>5/64</b>	<b>3/32</b>	<b>1/8</b>	<b>5/32</b>	<b>3/16</b>
<b>(mm)</b>	<b>1.6</b>	<b>2.0</b>	<b>2.5</b>	<b>3.25</b>	<b>4.0</b>	<b>5.0</b>