

HABCO ST 580 (S)

UNIVERSAL TYPE ALLOY FOR USE IN CRYOGENIC AS WELL AS HIGH HEAT APPLICATIONS. FOR DISSIMILAR COMBINATIONS OF STEEL, STAINLESS STEEL OR NICKEL BASE ALLOYS

FEATURES

The weld metal **HABCO ST 580** has excellent high temperature strength and oxide resistance. The universal properties give it the capability to be used as a joining electrode as well as a cladding or wear facing electrode. The special flux coating provides a high speed deposit that has a deposition rate of approximately 40% faster than conventional alloys. The deposit remains strong and tough over a wide temperature range.

APPLICATIONS

Excellent for use on parts that are subjected to thermal cycling, even to sub-zero temperatures. Used where good weld ductility is needed when joining and repairing massive sections. It is used on flame hardening equipment, heat equipment, cryogenic and dissimilar combinations of steels, stainless steels, Monels™, and Inconels™.

INSTRUCTIONS

Surface should be clean of any grease, oils, paint etc. Joint design and preparation should allow for the low penetration characteristics of **HABCO ST 580**, usually about 25% more opening than conventional joint openings. The electrode angle should be about 20% of vertical while welding in the flat position. Slight weaving is generally desirable. Slag should be removed between passes. Slag should be removed from surface, especially for high service temperature applications.

Tensile Strength: up to 90,000 Psi (63 kg/mm²)

Elongation: 30%

Heat Resistance: Excellent

Cryogenic use: Excellent

Scaling Resistance: Excellent

Current: DC +

Amperage:	35-70	50-105	80-140
Diameters: (in)	3/32	1/8	5/32
(mm)	2.5	3.25	4.0