

HABCO SA 333 (S)

A MICRO DENSE COATED SUPERIOR ALL POSITION CONTROLLED-HYDROGEN ELECTRODE

FEATURES

HABCO SA 333 has a specially formulated **micro-dense coating providing superior moisture resistance** which produces x-ray quality welds with superior impact properties even at sub-zero temperatures. This high quality, all position, low amperage electrode features rapid deposition. The proprietary electrode coating eliminates weld porosity and under bead cracking especially with sulphur and high phosphorus bearing steels. **Metal recovery of 120%.**

APPLICATIONS

For medium carbon steels, low alloy steels and cast steels.

SPECIFICALLY FOR "TRAMP" AND "PROBLEM" STEELS HIGH IN SULPHUR, PHOSPHORUS or other elements added to improve machinability of the steel. It can be used for both joining and build up. Excellent choice when welding of free machining steels or when overlaying worn parts such as shafts, hubs or castings prior to machining.

HABCO SA 333 is ideal for joining heavy sections that are highly restrained. Outstanding all position operation. For fabrication of "H" and "I" beams, angle and channel iron, and other type joints subject to stress and strain.

INSTRUCTIONS

Clean and prepare weld zone in accordance with standard welding practice. Maintain short arc length. Vertical joints should be welded from bottom up using a rapid weave or stringer technique for maximum strength. Do not whip.

Tensile Strength: up to 89,000 Psi (63 kg/mm²)

Elongation: up to 35%

Current: AC or DC ±

Amperage:	70-110	100-140	130-180	210-275	240-350
Diameters: (in)	3/32	1/8	5/32	3/16	1/4
(mm)	2.5	3.25	4.0	5.0	6.0

• Available in TIG form