

HABCO TX 964AH

PREMIUM QUALITY ELECTRODE FOR BUILD-UP AND REPAIR OF MOST TOOL STEELS – AIR HARDENING

FEATURES

HABCO TX 964 AH is ideally suited for the repair of most tool steels. The unique formulation of alloys will result in deposits, which are forgeable and temperable and also highly crack resistant. Excellent for out-of-position welding.

APPLICATIONS

For build-up and repair of tongs, guideways, tools, dies, shearing blades, strippers, deburrers and sheet punching tools. Also for machine parts of steel, cast steel and manganese steel which are subject to grinding wear combined with high impact.

INSTRUCTIONS

Clean the weld zone thoroughly. Preheating is not necessary. If the base metal is highly carbonized, it should be preheated to approximately 390°F (200°C). Build part to desired shape by using as many passes as necessary. Heat to a bright red; forge and grind to required dimension. Heat-treat and harden as you would for the base metal upon which the weld was applied. Final tolerance can be obtained by grinding.

Hardness (as welded): 55-60 RC

Current: AC or DC ±

Amperage:	40-95	80-120	100-150	140-190
Diameters: (in)	3/32	1/8	5/32	3/16
(mm)	2.5	3.25	4.0	5.0

- Available in (GTAW) TIG and (GMAW) MIG form