

HABCO TX 964HS (S)

PREMIUM ELECTRODE FOR REPAIR AND HARD FACING OF "HIGH SPEED" STEELS

FEATURES

HABCO TX 964HS was developed for use on high speed and hot working steels. Tungsten, Molybdenum and Vanadium have been alloyed with other elements in creating this high quality electrode. It is a simple and economical method to produce a deposit that maintains a sharp edge on high-speed tools and at the same time withstands elevated temperatures usually associated with these tools. The new cutting edges and overlays retain hardness and resistance to wear, often outperforming the original base metal.

APPLICATIONS

Commonly used for build-up and hardfacing of molding plates, hot shears, reamers, turning and planing tools, drawing mandrels and dies, circle cutting tools, trimming plates, stencils, punches, cams, lathe tools, mill cutters, de-barker and industrial knives.

INSTRUCTIONS

Remove all foreign material. Use minimum heat stringer beads. Three layers may be necessary to overcome base metal dilution on low carbon steels. On tool steel preheat the part to 800°-1100°F (425°-600°C). Do not quench after welding, remove slag and reheat to 1000°F (540°C), allow to cool slowly. Final tolerances can be obtained by grinding.

Hardness (as welded): 58-62 RC

Heat treated: 63-65 RC

Hot Hardness: approx. 56 RC @ 1100°F (600°C)

Current: AC or DC ±

Amperage:	45-90	80-120	100-160	125-190
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