

HABCO HF 962-0 **F**

**HIGH CHROME HARDSURFACING ALLOY FOR HIGH ABRASION
FLUX-CORED OPEN ARC WIRE - SELF SHIELDING**

FEATURES

This high chrome-moly alloyed hardsurfacing wire has excellent resistance to high abrasion and moderate impact. For use on mild, low alloy and manganese steels. Best results are obtained with a maximum of two layers. **HF 962-0** deposits are grindable and provide an excellent final overlay for **HABCO FROGSPEC®-0** and **HF 960-0**, as an example.

APPLICATIONS

HABCO HF 962-0 was developed for use on earth moving equipment, crusher jaws, drilling tools, hammers, concrete paddles, bucket and asphalt ripper teeth, farm implements and other equipment subject to severe abrasion and impact at either normal or elevated temperatures. Weld deposits will cross check to relieve stress.

INSTRUCTIONS

- Avoid overheating of manganese steel, keeping bulk of part below 550°F (288°C).
- Avoid thermal shock.
- Stick-out 2" - 3"
- Deposition rate: 10 - 20 lbs per hour.

Hardness as deposited: 60-62 RC

Current: DC +

Diameters: (in)	7/64 & 3/32	5/64	1/16	.045
(mm)	2.8 & 2.5	2.0	1.6	1.2

RANGES:

Amperage:	275 - 425	250 - 325	210 - 275	120 - 150
Voltage:	30 - 35	28 - 32	26 - 30	28 - 30
Optimums:	350 / 32	275 / 30	245 / 28	140 / 28

**PACKAGING: 10lb. & 28lb. Plastic Spools • 55 lb. Coils
100lb & 250lb. Pay-off Packs (7/64' & 3/32")**