

# HABCO HF 962MO-0 **F**

**HIGH CHROME - MOLY HARDSURFACING ALLOY FOR HIGH ABRASION RESISTANCE • 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.

## APPLICATIONS

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

## 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: 58-62 RC**

**Current: DC +**

<b>Sizes: (in)</b>	<b>7/64 &amp; 3/32</b>	<b>5/64</b>	<b>1/16</b>	<b>.045</b>
<b>(mm)</b>	<b>2.8 &amp; 2.5</b>	<b>2.0</b>	<b>1.6</b>	<b>1.2</b>
<b>RANGES:</b>				
<b>Amperage:</b>	<b>275 - 425</b>	<b>250 - 325</b>	<b>210 - 275</b>	<b>120-150</b>
<b>Voltage:</b>	<b>30 - 35</b>	<b>28 - 32</b>	<b>26 - 30</b>	<b>28 - 30</b>
<b>Optimums:</b>	<b>350 / 32</b>	<b>275 / 30</b>	<b>240 / 28</b>	<b>140 / 28</b>

**PACKAGING: 10lb. & 28lb. Plastic Spools • 55 lb. Coils**

**• 100lb & 250lb. Pay-off Packs (7/64 & 3/32 ONLY)**