



# HI-ALLOY 360

## HEAT AND CORROSION RESISTANT ALLOY

**DESCRIPTON:** Hi-Alloy 360 is designed for use in joining or overlay of steels and stainless steels where resistance to elevated temperatures, severe corrosion, and scaling is required. This product may also be used for welding dissimilar steels and unidentified grades of stainless steels.

**TYPICAL APPLICATIONS:** Furnace parts, heating plates, crucibles, ladles, combustion tubes, heat exchangers, oven linings & kilns up to 2100° F.

**PROCEDURES:** Clean the weld area, remove cracked, worn or corroded metal with Hi-Alloy Metal Mover or by grinding, bevel heavy sections, preheat high carbon steels to 300° – 500° F., maintain a short to medium arc length, use stringer beads, and remove slag between passes. Allow finished part to cool slowly in still air.

**AVAILABLE SIZES:**                    3/32                    1/8                    5/32

**AMPERAGE RANGES:**            55-75                75 -110            90-140

**POLARITY:**                            DC Reverse or AC

**TENSILE STRENGTH:**            Up to 84,000 psi

**YEILD STRENGTH:**                Up to 59,000 psi

**ELONGATION:**                        Up to 37%