



HI-ALLOY 500

THE ULTIMATE PROBLEM SOLVER FOR ALL STEELS

DESCRIPTION: Hi-Alloy 500 provides the ultimate performance in the repair of dissimilar steels and steels of unknown analysis. The unique complex alloy system of this product allows for dense porosity free welds to be made without danger of cracking. A special flux formulation gives this alloy exceptional arc stability even when used with AC "cracker box" welding machines.

TYPICAL APPLICATIONS: Use for the welding and repair of tool steels, spring steels, stainless steels, carbon steels, steels of unknown analysis, and dissimilar combinations of these metals. Also makes an excellent buildup and underlay for subsequent hardfacing procedures.

PROCEDURES: Clean the weld area; remove cracked or worn metal with Hi-Alloy Metal Mover or by grinding. Bevel heavy sections, preheat high carbon steels to 350° F, maintain a very short arc, use stringer beads and remove slag between passes. Allow finished part to cool slowly in still air.

AVAILABLE SIZES:	1/16	3/32	1/8	5/32	3/16
AMPERAGE RANGES:	25-35	35-70	60-110	75-140	130-200
POLARITY:	DC Reverse or AC				
TENSILE STRENGTH:	Up to 130,000 psi				
YEILD STRENGTH:	Up to 90,000 psi				
ELONGATION:	Up to 32%				