



HI-ALLOY HF507

FOR JOINING AND SURFACING COMPONENTS SUBJECT TO HIGH IMPACT

DESCRIPTION: Hi-Alloy HF507 has a high deposition rate (metal recovery rate 160%), and uses a spray transfer to produce smooth, non-cracking welds with an outstanding resistance to heavy impact.

TYPICAL APPLICATIONS: Since the deposited metal is not affected by heat treatment, HF 507 is ideally suited for repair and build-up of tools, dies, non-magnetic chrome and heat resistant steels. This product may also be used for joining of high alloyed to low alloyed steels and for surfacing of manganese steels, crusher hammers, rolls and mantles.

PROCEDURES: Clean the base metal and remove prior deposits of hardfacing material and fatigued metal. **DO NOT PREHEAT.** Prevent excessive heat build up of the work piece by maintaining a short arc length, particularly on manganese steels. Allow the finished part to cool slowly.

AVAILABLE SIZES:	1/8	5/32	3/16
AMPERAGE RANGES:	90-130	120-160	140-190
POLARITY:	AC or DC Reverse		
HARDNESS:	As Welded Up To Rockwell C 20 Work Hardens Up To Rockwell C 45		
TENSILE STRENGTH:	Up to 105,000 psi		
YIELD STRENGTH:	Up to 62,000 psi		
ELONGATION:	Up to 40%		