



HI-ALLOY HX905

TUBULAR, MULTI-CARBIDE HARDFACING ELECTRODE

DESCRIPTION: Hi-Alloy HX905 features a unique spray fusion metal transfer. The tubular construction allows this electrode to be operated at very low amperages. The low amperage characteristic and low heat input to the base metal make this product perfect for use on manganese steels. Multi-Carbide deposits provide resistance to extreme abrasion accompanied by moderate impact.

TYPICAL APPLICATIONS: Dredge bucket lips, crusher jaws, mantles and liners, swing hammers, screen plates, grizzly bars, shovel buckets, railway ballast sleds and tempers.

PROCEDURES: Clean the base metal and remove prior deposits of hardfacing material and fatigued metal. Deposit alloy using a moderately long arc length and a slow weave bead. Maximum deposit thickness is two layers. Be careful not to overheat manganese steels. For out of position welding weld down hand, or at a slight up hand angle for heavier build-up. Cross bead checking will occur as the deposit relieves itself of internal stresses.

AVAILABLE SIZES:	1/4	3/8	1/2
AMPERAGE RANGES:	80-150	120-250	150-290
POLARITY:	AC, DC Straight or DC Reverse		
HARDNESS:	Up to Rockwell C 62		