



HI-ALLOY HARDBASE 30

SUPERIOR BUILD-UP ALLOY

DESCRIPTION: Hi-Alloy Hardbase 30 was designed to offer tough yet machinable deposits which are exceptionally compression and impact resistant. It is an excellent choice for mild abrasion environments and as a cushion layer for harder overlays such as Hi-Alloy Super Surface 60. The weld deposit thickness is unlimited, may be forged and can be flame cut.

TYPICAL APPLICATIONS: Mine car wheels, rope winches, gear teeth, steel mill wobblers, tractor rollers, brake drums, couplings, and hardfacing underlay.

PROCEDURES: Clean base metal and remove all prior deposits of hardfacing material, weld using stringer or weave beads, remove slag between passes, allow part to cool in still air.

AVAILABLE SIZES: 1/8 5/32 3/16

AMPERAGE RANGES: 90 - 110 120 - 140 160 - 180

POLARITY: DC Reverse, DC Straight, or AC
Use DC Straight to Accelerate Deposition Rate

HARDNESS: Up to Rockwell C 38