



HI-ALLOY HARDFACE 60

RESISTS ABRASION AND IMPACT

DESCRIPTION: Hi-Alloy Hardface 60 was designed to create a deposit which is resistant to severe abrasion coupled with light to moderate impact. It may be used on cast iron; manganese steels and low alloy steels as well as standard carbon steels. The deposit has very good resistance to small particle erosion and will polish smoothly to aid against frictional wear. This product also has excellent out of position surfacing characteristics and hot hardness retention up to 1000° F.

TYPICAL APPLICATIONS: Bucket teeth, cement chutes and augers, scraper blades, crusher jaws and rolls, conveyors and many other uses in the mining, earth moving and brick making industries.

PROCEDURES: Clean the base metal and remove all prior deposits of hardfacing material. Limit buildups to 2 passes, for heavy buildup or impact applications use Hi-Alloy Hardbase 30 for buildup or cushioning layers. Deposit using stringer or weave technique but be careful not to overheat the base metal especially if welding on manganese steels. A butter layer of Hi-Alloy 400 is recommended before use on cast iron. Finished part should be allowed to cool slowly.

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

AMPERAGE RANGES: 90 - 130 120 - 170 140 - 200

POLARITY: AC or DC Reverse

HARDNESS: Up to Rockwell C 60