



HI-ALLOY SX947

FOR BUILD-UP AND JOINING OF ALL STEELS

DESCRIPTION: Hi-Alloy SX947 is a high deposition electrode designed with a unique dual flow coating. The deposit chemistry was formulated to work well with all steels containing medium to very high carbon levels, on hardenable steels or where shock stresses are anticipated, by utilizing an exact percentage of ferrite formers to neutralize the effects of carbon pick-up in the weld deposit, thus eliminating central bead and side bead cracking in such steels.

TYPICAL APPLICATIONS: Due to its high elongation, work hardening characteristics, and high heat resistance, Hi-Alloy SX947 can be safely used for joining and build-up of low to high carbon steels, cast steels, tool steels, hot working steels, and austenitic manganese steels.

PROCEDURES: Clean the base metal and remove prior deposits of hardfacing material. Bevel heavy sections. Hold a short arc or drag the electrode. Use stringer beads. For high alloy steels or heavy sections preheat to 400° F. Skip weld and peen deposits to distribute internal stresses.

AVAILABLE SIZES:	3/32	1/8	5/32	3/16	1/4
AMPERAGE RANGES:	40-70	60-90	80-130	120-180	150-220
POLARITY:	AC or DC Reverse				
HARDNESS:	As Welded Up To HB 240 Work Hardens Up To HB 350				
TENSILE STRENGTH:	Up to 112,000 psi				
YIELD STRENGTH:	Up to 90,000 psi				
ELONGATION:	Up to 35%				
HEAT RESISTANCE:	Up to 1300° F				