



HI-ALLOY SUPER 600

SUPER ALLOY FOR HIGH NICKEL AND STAINLESS STEELS

DESCRIPTION: Hi-Alloy Super 600 is an outstanding alloy for cladding and joining nickel alloys, stainless steels, carbon steels, and dissimilar combinations of these alloys. Weld deposits can withstand temperature extremes from -140° to +1900° F. This electrode offers exceptional weld characteristics and bead appearance even when used with small AC machines. Deposits exhibit exceptional oxidation and corrosion resistant properties.

TYPICAL APPLICATIONS: A universal repair alloy for use in refineries, paper mills, and chemical plants.

PROCEDURES: Clean the weld area and remove oxides, grease, and oils. Use the lowest possible amperage which provides a short stable arc and good wetting characteristics. Use stringer beads or weave with 3 times the electrode diameter. Allow the part to cool in still air.

AVAILABLE SIZES:	3/32	1/8	5/32
AMPERAGE RANGES:	70 - 95	100 - 135	130 – 175
POLARITY	DC Reverse or AC		
TENSILE STRENGTH:	Up to 136,000 psi		
YIELD STRENGTH:	Up to 95,000 psi		
ELONGATION:	Up to 40%		
HARDNESS:	As Welded 22 RC Work Hardens Up to 45 RC		
IMPACT PROPERTIES:	65 Joules at -320° F		