



# HI-ALLOY THS-1

## TUBULAR HARDFACING ELECTRODE

**DESCRIPTION:** Hi-Alloy THS-1 is a uniquely formulated welding alloy. It contains a blend of chromium carbides and special alloy supplements that are extremely abrasion resistant. The weld deposit is very hard and designed to resist all forms of abrasion where light to moderate impact is present.

**TYPICAL APPLICATIONS:** Hi-Alloy THS-1 can be applied to all weldable steels. It is particularly well suited for surfacing components subjected to severe abrasion or erosion by wet highly siliceous sands and mineral slurries such as; scraper blades, augers, sand chutes, bucket lips and teeth.

**PROCEDURES:** Remove all surface contaminates and weakened metal by grinding or using Hi-Alloy Metal Mover electrodes. Use Hi-Alloy Hardbase 30 to buildup heavily worn areas so that no more than two (2) passes of THS-1 are needed to complete the procedure. Position the part so that flat or horizontal welds can be made. Deposits must be ground to final desired finish.

**AVAILABLE SIZES:**                      3/16                      1/4

**AMPERAGE RANGES:**                60 - 110                70 - 150

**POLARITY:**                                AC or DC Reverse

**HARDNESS:**                                Up to Rockwell C 64