



TEXAS * PENNSYLVANIA * NORTH CAROLINA
<http://hi-alloy.com>

HI-ALLOY HARDFACE 50

MEDIUM DUTY HARDFACING ELECTRODE

DESCRIPTION: Hi-Alloy Hardface 50 is designed to produce deposits which have medium property characteristics for hardness, and resistance to impact and abrasive wear. It is primarily for flat and horizontal welding but its superior arc stability helps it perform well out of position also. This product may be used on alloyed steels, carbon steels, manganese steels, and cast irons.

TYPICAL APPLICATIONS: Overlay and repair of worn edges on scraper blades, feed screws, crusher rolls, auger points, disc plows, grain chutes, and mill hammers.

PROCEDURES: Clean the base metal and remove prior deposits of hardfacing material and fatigued base metal. Full hardness is normally achieved with 2 - 3 passes. If required, buildup soft or badly worn areas with Hi-Alloy Hardbase 30. Deposit using stringer or weave techniques but be careful not to overheat manganese steels.

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

AMPERAGE RANGES: 100 - 130 120 - 175 140 - 200

POLARITY: AC or DC Reverse

HARDNESS: Up to Rockwell C 53