



S. R. Industries

STAR ARC HC400

HardCover 400 (HC400) is a tubular, self-shielded wire for metal arc hardfacing. It produces a martensitic weld metal with good abrasion and impact resistance. This alloy is especially applicable in applications of 2-3 layers for wear resistance. HC400 should be considered when good resistance to abrasion and impact in dry or wet environments are required.

Typical Applications :

- Bucket teeth, lips, undersides and cutting edges
- Steel mill rolls
- Cable drums
- Sand dredge equipment
- Dragline buckets
- Conveyor chutes

Specification :

<i>AWS Classification</i>	<i>Hardfacing</i>
<i>Welding Current</i>	<i>DCEN</i>
Typical wire chemistry (As Welded)	
<i>C</i>	<i>0.5</i>
<i>Mn</i>	<i>1.5</i>
<i>Si</i>	<i>2.5</i>
<i>Cr</i>	<i>8.5</i>
<i>Fe</i>	<i>BAL</i>
Typical Mechanical Properties (As Welded)	
<i>Hardness on 3 layers, Rc</i>	<i>61</i>
<i>Welding Positions</i>	<i>F, H</i>
Available Diameters and suggested Operating Range in Amps	
<i>.045"</i>	<i>100 - 300</i>
<i>1/16"</i>	<i>150 - 350</i>
<i>3/32"</i>	<i>250 - 400</i>

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