



# S. R. Industries

## STAR ARC HC440

**Hard Cover 440 (HC440)** is a tubular, self-shielded wire for metal arc hard facing. It produces a low alloy steel weld deposit for heavy multi-layer build-up work on carbon steel parts. HC440 is used for rebuilding and resurfacing components subject to metal-metal wear and moderate abrasion. The weld deposit is machinable.

### Typical Applications :

- Build-up of earthmoving equipment such as tractor rollers, idlers, chains and drive sprockets
- Excavator pads
- Electric shovel track carrier rolls
- Steel shafts
- Gears
- Crane wheels
- Steel mill rolls
- Mine car wheels
- Railcar couplings

### Specification :

|  |                   |
|--|-------------------|
| <i>AWS Classification</i>  | <i>Hardfacing</i> |
| <i>Welding Current</i>   | <i>DCEN</i>       |
| <i>Typical wire chemistry (As Welded)</i>                        |                   |
| <i>C</i>   | <i>0.15</i>       |
| <i>Mn</i>  | <i>1.5</i>        |
| <i>Si</i>  | <i>0.8</i>        |
| <i>Cr</i>  | <i>1.5</i>        |
| <i>Fe</i>  | <i>BAL</i>        |
| <i>Typical Mechanical Properties (As Welded on mild steel)</i>   |                   |
| <i>Hardness on 3 layers</i>                                      | <i>360 HB</i>     |
| <i>Welding Positions</i>   | <i>F,H</i>        |
| <i>Available Diameters and suggested Operating Range in Amps</i> |                   |
| <i>.045"</i>   | <i>120 - 320</i>  |
| <i>1/16"</i>   | <i>150 - 350</i>  |
| <i>3/32"</i>   | <i>200 - 450</i>  |

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