

HABCO MT 993

A TUBULAR SPRAY FUSION TRANSFER, HARDFACING ELECTRODE, WITH SUPER HARD DEPOSITS FOR EXTREME ABRASION AND GOOD IMPACT RESISTANCE

FEATURES

Due to the unique spray fusion transfer deposit feature of **HABCO MT 993** and the minimum dilution in base metal, full hardness can be obtained with two layers. **HABCO MT 993** a low amperage requirement, which allows this alloy to be used with ALL WELDING MACHINES. Low amperage operation virtually eliminates the problems associated with over heating of manganese steels. No cushion layer is required for deposits on low carbon, gray cast and austenitic manganese steels.

APPLICATIONS

Ideal for parts subjected to severe abrasion bulldozer end bits, conveyer chains in annealing furnaces, pan scraper blades, brick extrusion augers and other equipment used in the rock, coal, cement, and ceramic industries where small particle abrasion resistance is a problem.

INSTRUCTIONS

Remove unsound base metal using **HABCO MX 222**. Deposit alloy using a moderately long arc length and a slow weave bead. Two layer deposit maximum. Cross-checking will occur as the deposit relieves itself of internal stress. For out-of position welding, weld down-hand, or at a slight up-hand angle for heavier build-up.

Hardness as welded: 60 - 62 RC

Deposit Efficiency: up to 96%

Current: AC or DC $\pm$

Amperage:	80-150	120-250	180-350
Diameters: (in)	1/4	3/8	1/2
(mm)	6.0	9.0	12.0