HS-2

WELDING ROD TO CLAD STEEL SUBMITTED TO EXTREME WEAR BY ABRASION.

APPLICATIONS: The possible applications are special cases where very hard surfacing is needed for parts submitted to intense abrasion and little impact as in the case of excavation machinery, backhoes, bulldozers, concrete mixers, dredgers, stone crushing equipment, sand pumps, mixing blades, cat crawl buckets, sieves and dirt moving equipment, mill parts and also for parts submitted to abrasion, heat and corrosion wear.

CHARACTERISTICS: HS-2 has been formulated with a special alloy with excellent abrasion resistance and little impact resistance. Its filler metal deposits can be highly polished and it is self-polishing when it works on dirt, clay and sand. Its filler metal deposits are not machinable and do not admit heat treatment. This welding rod is easy to apply and to control. It is particularly suitable for open circuit welding units which operate with low voltage. Clean the joint area. Keep the arc medium. Use a slightly weaving motion. Whenever wider and shallower filler metal deposits are required, use a longer arc. Be careful not to overheat the base metal too much since this decreases hardness as a result of dilution. If more than two layers of cladding are required to restore the original part dimensions, use Vilchis 30 as the intermediate cladding electrode. This will help to minimize not onlly the cracks but also the dilution of HS-2.

ROCKWELL "C" HARDNESS:	BETWEEN 56 AND 62
POSITIONS:	ALL
CURRENT: :	AC OR DC REVERSE POLARITY
IMPACT RESISTANCE:	MODERATE
ABRASION RESISTANCE:	EXCELLENT

FILLER METAL CHEMICAL ANALYSIS %				SIZES	AMPERAGE
C	**Cr**	**Mn**	**Si**	3.25 mm - 1/8"	100-130
3.00	24.0	1.0	0.6	4.0 mm - 5/32"	160-180
				5.0 mm - 3/16"	200-250