



Hi-Brade™

High-Abrasion/Moderate-Impact Alloy

Hi-Brade produces iron-chromium carbides, which exhibit exceptional hardness and abrasive wear resistance.

- High deposition rate — economical for fast overlays
- High abrasion resistance — particularly sliding and scratching modes of abrasion
- Impact-resistant — handles moderate levels of impact
- Resists hot wear to 1000°F/586°C
- Smooth running
- Deposits will cross check crack for stress relief
- For use on carbon and abrasion-resistant alloy steels including manganese steels



SPECIFICATIONS

Hardness	58 Rc
Machinability	Grind only
Max number of passes	3
Current.....	DCEP (DC+) or AC
ASTM G65 abrasion test.....	171.17 mm ³ volume loss



PROCEDURE

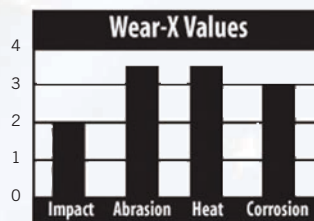
Clean the weld area and remove any unsound, fatigued or corroded metal from the surface using Arc-Prep electrodes. Generally the work does not require preheating, but some alloyed or high-carbon steel should be preheated to 400°-600°F (204°-316°C) for the first pass. Postheat treatment is seldom required.



APPLICATIONS

- Mine haulpak trucks
- Ripper teeth
- Loader buckets
- Conveyor chains
- Bucket lips
- Augers
- Sub-soiler teeth
- Plows

Code #	Diameter	Amperage
174-2-0000	3/16"	170-250
174-3-0000	5/32"	160-200
174-4-0000	1/8"	110-140
174-5-0000	3/32"	80-110



DOD EMALL
<https://dod.emall.dia.mil>
 SP47W1-17-D-0009
 Available in select sizes only