



S. R. Industries

STAR ARC HC430

HardCover 430 (HC430) is a tubular, self-shielded wire for metal arc hardfacing. It is an austenitic manganese steel type alloy used for build-up and reinforcing manganese steel castings and wear components. It has excellent work hardening properties. The degree of work hardening is dependent on the amount of impact on the rebuilt component. HC430 should be considered when rebuilding 14% manganese steel parts.

Typical Applications :

- Reclaiming crusher jaws and rolls
- Gyratory mantles
- Blow bars
- Swing hammers
- Manganese dredge components
- Railroad sections
- Bucket teeth and lips

Specification :

| | |
|--------------------------------------------------------------------|-------------------|
| <i>AWS Classification</i> | <i>Hardfacing</i> |
| <i>Welding Current</i> | <i>DCEN</i> |
| Typical wire chemistry (as welded) | |
| <i>C</i> | <i>1</i> |
| <i>Mn</i> | <i>14</i> |
| <i>Si</i> | <i>0.5</i> |
| <i>Cr</i> | <i>3.5</i> |
| <i>Ni</i> | <i>1</i> |
| <i>Fe</i> | <i>BAL</i> |
| Typical Mechanical Properties (As welded and work hardened) | |
| <i>Hardness on 3 layers, Rc</i> | <i>46</i> |
| <i>Welding Positions</i> | <i>F,H</i> |
| Available Diameters and suggested Operating Range in Amps | |
| <i>.045"</i> | <i>160 - 280</i> |

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|--------------|------------------|
| | |
| <i>1/16"</i> | <i>200 - 350</i> |
| <i>3/32"</i> | <i>250 - 450</i> |

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