



S. R. Industries

STAR ARC HC480

Hard Cover 480 (HC480) is a joining and cladding electrode for manganese steel that can be flame cut. Commonly used in the re-pair of rail equipment and construction equipment manufactured of manganese steel. The microstructure of this alloy in the as-deposited condition consists of a soft manganese alloy austenite which rapidly work hardens under impact loading.

Typical Applications :

Ideal for railroad frogs, switches, crossings and for wear plates, bucket teeth, bucket lips, and associated manganese steel parts. Also recommended for sheep foot tampers, hammers, crushers, and a variety of parts designated to resist impact.

Specification :

<i>AWS Classification</i>	<i>Hardfacing</i>
<i>Welding Current</i>	<i>AC - DCEN</i>
Typical wire chemistry (As Welded)	
<i>C</i>	<i>0.6</i>
<i>Ni</i>	<i>3.65</i>
<i>Mn</i>	<i>16</i>
<i>Si</i>	<i>0.08</i>
<i>S</i>	<i>0.01</i>
<i>P</i>	<i>0.015</i>
<i>Cr</i>	<i>3.75</i>
<i>Fe</i>	<i>BAL</i>
Typical Mechanical Properties (As Welded)	
<i>Tensile strength, ksi</i>	<i>116</i>
<i>Elongation%, min</i>	<i>38</i>
<i>Work hardness</i>	<i>41 - 54 Rc</i>
<i>Welding Positions</i>	<i>F, V-up, DH, H</i>

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<i>Available Diameters and suggested Operating Range in Amps</i>	
<i>1/8"</i>	<i>90 - 125</i>
<i>5/32"</i>	<i>125 - 170</i>
<i>3/16"</i>	<i>160 - 225</i>

Note : Clean base metal of oils and fatigued sections, and do not allow weld inter pass temperature to exceed 500°F.

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