

# CARBALOY 5HD

## A HIGH ALLOY ELECTRODE FOR JOINING AND BUILD-UP OF AUSTENITIC MANGANESE STEELS FOR EXTREME IMPACT RESISTANCE

**AC OR DC REVERSE POLARITY (ELECTRODE+)**

### GENERAL CHARACTERISTICS:

This high chromium, high manganese alloy is for joining and rebuilding manganese and carbon steel parts. The high alloy deposits are very tough and will take extreme impact and abrasion conditions. Has excellent weldability with very low spatter. Operates easily in all positions.

### APPLICATIONS:

For rebuilding and joining austenitic manganese steels and manganese steels to other steel combinations. Especially designed for high impact applications such as rail frogs and switch points, roller crushers, hammers, shovel tracks. Carbaloy 5HD is also excellent for use as a base for harder overlays.

### TECHNICAL DATA:

Hardness ..... as deposited: Rc 16-28

..... work hardens to: Rc 45

Current ..... AC or DC reverse polarity (electrode+)

Amperage 110-135 125-190 150-250

(in)	1/8"	5/32"	3/16"
(mm)	3.25	4.0	5.0

### PROCEDURE:

Remove any hardened or fatigued material from the surface with Chamferrode. Deposits may be placed with either the stringer bead or weaving technique. This electrode deposits easily in all positions with excellent build-up quality. Avoid over-heating on manganese steel base metals. Deposits work harden rapidly.