

**UNITED ALLOYS**  
RESEARCH & DEVELOPMENT INC.

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# 9120HP

## A DENSE, TOUGH, SEMI-HARD MACHINABLE ALLOY FOR REBUILDING WORN PARTS

### GENERAL CHARACTERISTICS:

9120HP is a high nickel chromium bearing alloy that combines good machinability with good wear qualities. The deposits are extremely tough and will withstand severe impact. The dense deposit of 9120HP gives it a good low coefficient of friction. This versatile alloy has excellent weldability with good build-up qualities and machinability.

### APPLICATIONS:

The combined qualities of toughness, friction, abrasion, and impact resistance make it ideal for heavier build-ups that require machining, used for tooth build-ups or shaft repairs, including worn keyways. Often used as a medium hardfacing alloy, especially where corrosion may be a factor. It can be used on all ferrous and nickel base alloys.

### TECHNICAL DATA:

9120HP is a high nickel, high chromium alloy. The high alloy chemistry and density of deposit enhance its corrosion resistance and machinability. The synergistic elements in the alloy chemistry give it superior wetting capability on most metals.

Hardness .....Rc 37-40

### PROCEDURE:

The area to be overlaid should be cleaned just before applying. Preheat the entire area to 600°F (on steel, a blue tint will be noticed.) Spray a thin layer of powder alloy over the entire area keeping the torch tip approximately 2-3 inches from the workpiece. Without spraying any more alloy, position the tip about 3/4" to 1" above the workpiece and wet the alloy out. If a thicker deposit is required, repeat the process.

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UNIVERSAL 9120HOT SPRAY