



S. R. Industries

STAR ARC HC420

HardCover 420 (HC420) is a high chromium cast iron for hardsurfacing components subject to extremely severe abrasive wear and moderate impact. The weld deposit contains a high proportion of hard primary chromium carbides in a tough austenitic matrix. HC420 is used for hardfacing components undergoing wear by earth, sand and abrasives.

Typical Applications :

- Gyrotory crusher cones and mantles
- Catalyst pipes and valves
- Slurry pipes and valve bodies
- Dredge pump bodies
- Sand dredge parts
- Extruder screws
- Mining and earth moving equipment

Specification :

<i>AWS Classification</i>	<i>Hardfacing</i>
<i>Welding Current</i>	<i>DCEN</i>
Typical wire chemistry (as welded)	
<i>C</i>	<i>5</i>
<i>Mn</i>	<i>1.5</i>
<i>Si</i>	<i>1.5</i>
<i>Cr</i>	<i>27</i>
<i>Fe</i>	<i>BAL</i>
Typical Mechanical Properties (As Welded)	
<i>Hardness on 3 layers, Rc</i>	<i>60</i>
<i>Welding Positions</i>	<i>F,H</i>
Available Diameters and suggested Operating Range in Amps	
<i>.045"</i>	<i>100 - 300</i>
<i>1/16"</i>	<i>150 - 350</i>
<i>3/32"</i>	<i>250 - 400</i>

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