



# S. R. Industries

## STAR ARC HC460

**Hard Cover 460 (HC460)** is an economical, general hard facing electrode where some impact is combined with abrasion. In the as-deposited condition, the micro structure consists of martensite and some carbides. This is a great hard facing electrode for low open circuit voltage AC welding machines.

### Typical Applications :

Surfacing and build-up of worn and new machine parts of cast steel, steel and man-ganese steel, used for earth borders, cater-pillar drives, stampers, shovel teeth, pressure rollers, conveyors, hammer mill parts, crusher jaws, and dredger teeth.

### Specification :

AWS Classification	Hard facing
Welding Current	AC - DCEN
Typical wire chemistry (As Welded)	
C	0.56
Mn	0.95
Si	0.43
P	0.018
S	0.014
Cr	5.7
Ni	0.03
Mo	0.63
Fe	BAL
Typical Mechanical Properties (As Welded)	
Hardness	56 - 58 Rc
Welding Positions	F,H
Available diameters and suggested Operating Range in Amps	
1/8"	100 - 130
5/32"	150 - 190
3/16"	200 - 260

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