



# S. R. Industries

## STAR ARC HC470

**Hard Cover 470 (HC470)** is a chromium car-bide electrode used in smooth overlays for protecting most iron base surfaces against severe abrasive wear and moderate impact. The micro structure of this alloy consists of austenitic alloy matrix and chromium/complex carbides. HC470 is specially formulated to totally eliminate the 'worm tracking' type porosity commonly found in this alloy group.

**Typical Applications :** Crusher jaws, hammers, bucket lips and-teeth. Wear plates, pins, axles, shafts, cams, eccentrics.

**Specification :**

|  |            |
|--|------------|
| AWS Classification   | Hardfacing |
| Welding Current  | AC - DC    |
| <b>Typical wire chemistry<br/>(As Welded)</b>                    |            |
| C  | 3.8        |
| Ni   | 0.14       |
| Mn   | 0.13       |
| Cu   | 0.09       |
| Si   | 0.59       |
| S  | 0.019      |
| P  | 0.017      |
| Cr   | 34         |
| Fe   | BAL        |
| <b>Typical Mechanical Properties<br/>(As Welded)</b>             |            |
| Hardness   | 55 - 60 Rc |
| Welding Positions  | F,H        |
| <b>Available Diameters and suggested Operating Range in Amps</b> |            |
| 3/32"  | 45 - 90    |

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|              |                  |
|--------------|------------------|
|              |                  |
| <i>1/8"</i>  | <i>80 - 120</i>  |
| <i>5/32"</i> | <i>110 - 160</i> |

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