



Hardalloy® 148

HARD SURFACING ELECTRODE

Overlay

Replaces HS-138

220-I INDEX: 981201

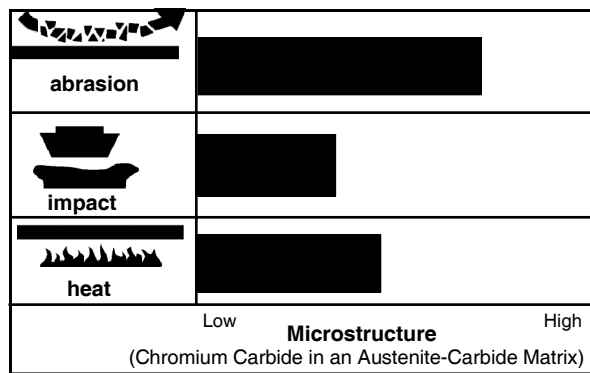
DESCRIPTION:

Hardalloy 148 deposit is a high carbon-chromium austenitic plus carbide alloy steel suited to overlay surfaces subjected to light abrasion accompanied by impact. It has excellent metal-to-metal frictional wear resistance, and the deposit retains hardness at temperatures up to 1200°F.

OPERATIONAL CHARACTERISTICS:

Hardalloy 148 has a very quiet stable arc and very fast transfer. The deposits are sound and covered with an easily removed slag. Minimum penetration and good wetting characteristics are other added features. It also has an excellent edge building capability. Deposit shows shiny surface like that of stainless steels.

RELATIVE WEAR RESISTANCE:



TYPICAL WELD METAL PROPERTIES* (CHEM PAD):

Weld Metal Analysis	
Carbon (C)	1.80
Manganese (Mn)	0.60
Silicon (Si)	1.80
Chromium (Cr)	30.00
Nickel (Ni)	3.00
Molybdenum (Mo)	1.50
Iron (Fe)	Bal.

TYPICAL MECHANICAL PROPERTIES* (AS WELDED):

	Number of Layers	As-Deposited on	
		1020 Steel	12-14% Mn Steel
Hardness	1	36 Rc	35 Rc
	2	39 Rc	38 Rc
	3	43 Rc	40 Rc

Low stress abrasion - excellent

Maintains hot hardness to 1200°F

Cannot be flame cut

Machinability - grinding only

Little or no relief checks

*The information contained or otherwise referenced herein is presented only as "typical" without guarantee or warranty, and McKay expressly disclaims any liability incurred from any reliance thereon. No data is to be construed as a recommendation for any welding condition or technique not controlled by McKay.



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RECOMMENDED OPERATING PARAMETERS:

Diameter		Type of Power	Optimum Amps	Deposition Rate
Inches	mm			
1/8	3.2	DCEP* or AC	120	3.6
5/32	4.0	DCEP* or AC	160	5.0
3/16	4.8	DCEP* or AC	175	6.0

*Preferred

†Typical at optimum settings

Note: To maximize deposition use higher amperages. To minimize penetration (and dilution) use lower amperages.

AVAILABLE DIAMETERS AND PACKAGES:

Diameter		Length		10-lb. Can
Inches	mm	Inches	mm	
1/8	3.2	14	355	S541044-033
5/32	4.0	14	355	S541051-033
3/16	4.8	14	355	S541058-033

APPLICATIONS:

- Gyratory Crusher Mantles and Cones
- Ingot Tongs
- Mill Guides
- Pulleys
- Slurry Mixer Paddles

Material Safety Data Sheets on any McKay product may be obtained from McKay Customer Service.

Because McKay is constantly improving products, McKay reserves the right to change design and/or specifications without notice.

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