

# Hardalloy<sup>®</sup> 148



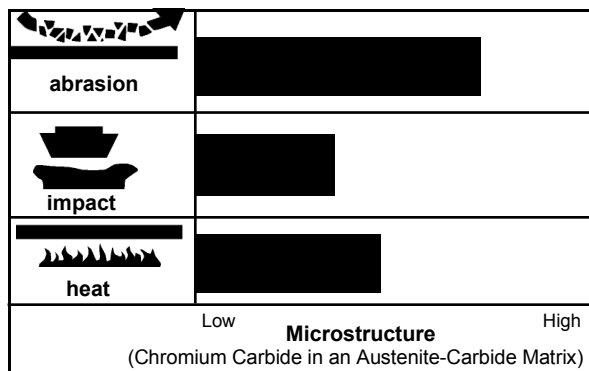
## DESCRIPTION:

**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 Hobart Brothers Company 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 Hobart Brothers Company.

# Hardalloy<sup>®</sup> 148

## 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

**TECHNICAL QUESTIONS?** For technical support of Hobart Filler Metals products, contact the Applications Engineering department by phone toll-free at 1-800-532-2618 or by e-mail at [Applications.Engineering@hobartbrothers.com](mailto:Applications.Engineering@hobartbrothers.com)

### CAUTION:

Consumers should be thoroughly familiar with the safety precautions on the warning label posted in each shipment and in the American National Standard Z49.1, "Safety in Welding and Cutting," published by the American Welding Society, 8669 NW 36 St, # 130, Doral, FL 33166-6672 (can also be downloaded online at [www.aws.org](http://www.aws.org)); OSHA Safety and Health Standards 29 CFR 1910 is available from the U.S. Department of Labor, Washington, D.C. 20210

Material Safety Data Sheets on any Hobart Brothers Company product may be obtained from Hobart Customer Service or at [www.hobartbrothers.com](http://www.hobartbrothers.com).

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

Hobart and Hardalloy are registered trademarks of Hobart Brothers Company, Troy, Ohio.

Revision Date: 140829 (Replaces 981201)  
220-I, INDEX

