

## SUPER 840 HT

- Welds Dissimilar Metals
- Excellent Elongation (35%)
- Wear & Shock Resistant
- Excellent out of Position
- Welds Manganese to Steel
- Low Heat
- Spray Transfer

### DESCRIPTION

Super 840 HT is a lower alloyed version of Super 860 HT. It is designed for applications where the base metals are dissimilar or of an unknown type. Deposits are duplex in nature which allows for carbon steel to stainless applications. The microstructure of 840 HT remains dual phase (duplex) even with considerable dilution by austenite forming elements, such as nickel. The deposit is thus highly resistant to weld metal cracks and fissures even at elevated temperatures (over 1000°F). In addition, the specifically formulated, highly stabilized flux enables low heat, all position welding without the characteristic arc blow common to standard types.

### TECHNICAL DATA

Tensile Strength: 125,000 psi (2" Bar)

Yield Strength: 111,000 psi

Elongation: 35%

Hardness: 34Rc

Current: AC/DC (DCEP) +/- 25%

### AVAILABILITY

3/32", 1/8", 5/32", 3/16"