



## HH 264 DM HIGH ALLOY STEEL

AC/DC REVERSE ELECTRODE

### General Characteristics

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HH 264 DM is a versatile, easy to use, low heat maintenance welding alloy for joining and building up most steels. It has a special ferritic - austenitic deposit, therefore the microstructure remains two phase and produces a highly crack resistant deposit. It has good high temperature and corrosion resistance. The special flux formulation eliminated slag interference in horizontal fillets and allows for welding in all positions, and the low heat input ensures dense, spatter free deposits that are fully machinable.

### Procedure

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Clean the surface to be welded of oil, grease, rust, and paint. Heavy sections should be beveled to 90°. Normally, preheat is not necessary, but on special high carbon alloys, a preheat of 200° C (400° F) is recommended. Maintain a short arc and use the lowest possible amperage, which will produce a finely rippled weld deposit with easy slag removal.

### Application

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HH 264 DM may be used to join dissimilar steels, for build-up on all types of steel, for tool and die repair, spring steel, and any dissimilar metal combinations, except for the aluminum and copper alloys. It is also used as a cushion layer for extremely hard overlays. Also used very effectively for removing broken studs.

Tensile Strength	128,000 PSI
Work Hardens to	186,000 PSI
Yield Strength	90,000 PSI
Elongation	32%
Hardness HB (Brinell)	approx. 300
Impact Strength	50 J: 68° F

	1/16	3/32	1/8	5/32	3/16
Diameter (Inch)					
(mm)	2.5	3.25	4.0	5.0	
Amps (approx.)	25-35	35-70	60-110	70-140	130-200

\*Also available in TIG WIRE: 1/16, 3/32, 1/8 by 36" lengths.