

The following is an excerpt the LaBounty Safety, Operation & Maintenance Manual (p. 4-20) for Mobile Shears:

HARDSURFACING RECOMMENDATIONS

For hardsurfacing, Stanley LaBounty recommends AmAlloy 814H rod. It is important to always use a hardsurfacing weld material with a chromium content of less than 10% and a severe impact-resistance rating to prevent cracking.

If in doubt about what hardsurface material to use, please contact the Stanley LaBounty Customer Service Department. Failure to adhere to LaBounty hardsurfacing recommendations may compromise the attachment warranty.

Hardsurfacing should be applied directly on top of the build-up welds. The build-up acts as a bonding or underlayment for the hardsurfacing. This reduces the chances that the hardsurfacing will crack.

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NOTE

Do not use stainless hardsurface rod. It is too brittle for LaBounty® applications and has a tendency to crack, weakening the base metal.