



SELECTARC HB600HT

Hardfacing Electrode for Metal/Metal Wear

Classification

DIN 8555 : E3-UM-60-ST EN 14700 : ~ E Fe3

Characteristics

Rutile coated electrode with a Cr-Mo-C martensitic alloy deposit, resistant to metal / metal wear up to 550°C. For all components subject to hot or cold metal abrasion. Even in the presence of shocks and pressure. Weld deposit is machinable by grinding. Soft arc, no spatters, self releasing slag.

Applications

Hardfacing of Shear Blades, Moulds, Pressing and Forging Dies.

Typical Weld Metal Composition (%)

C	Si	Mn	Cr	Mo	Fe
0.50	0.70	0.50	6.00	5.00	base

All Weld Metal Mechanical Properties (Typical)

Hardness (HRC)

AW (Obtained on pure weld metal)

58 - 61

Welding Current & Instructions

Electrode	ØxL (mm)	2.5 x 350	3.2 x 350	4.0 x 450
Current	(A)	70 - 90	110 - 120	140 - 160

Redrying of electrode at 250°C for 1hr before use. Low alloyed, high carbon tool steels etc. have to be preheated to 250 – 450°C, depending on their composition and thickness. Slow cooling in still air after surfacing.



1G/PA



2F/PB



2G/PC



3G/PF



4G/PE

= + ~ 45 V

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