



SELECTARC HB61R

Resistant to Impact
Compression & Abrasion

Classification

DIN 8555 : E6-UM-60-S EN 14700 : E Fe8

Characteristics

Rutile-basic coated general purpose hardfacing electrode for applications subject to impact, compression and abrasive wear. For hardfacing on components made of C-steel, Cast steel and Manganese steel. The deposit is tough and crack resistant. Metal recovery of the electrode approx. 120%.

Applications

Hardfacing of Block presses, Crusher jaws, Wheel rims, Rollers, Caterpillar tracks, Ploughshares, Running surfaces, Cutting edges etc.

Typical Weld Metal Composition (%)

C	Si	Mn	Cr	V	Mo	Fe
0.40	1.00	1.00	9.00	1.00	1.00	base

All Weld Metal Mechanical Properties (Typical)

Hardness (HRC)

AW (Obtained on pure weld metal)

60

Welding Current & Instructions

Electrode	ØxL (mm)	2.5 x 350	3.2 x 350	4.0 x 450
Current	(A)	60 - 90	90 - 120	110 - 160

Redrying of electrode at 300°C for 2hrs before use. Guide electrode almost vertically with a short arc. On materials sensitive to cracks a buffer-layer with selectarc 18/8Mn is recommended. Low alloyed, high carbon tool steels etc. have to be preheated to 200 – 400°C, depending on their composition and thickness. Slow cooling in still air after surfacing.



1G/PA



2F/PB



2G/PC

= + ~ 50 V

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