



SELECTARC HB63

High Efficiency Electrode for Hardfacing

Classification

DIN 8555 : E 10-UM-60-GRPZ EN 14700 : E Fe 14

Characteristics

Rutile coated synthetic hardfacing electrode with high recovery (160%), for applications subject to abrasive wear by minerals, combined with medium shocks and compression. Austenitic matrix containing Cr carbides. The deposit resists to corrosion due to the high chromium content as well as heat upto 200°C. Easy flow, smooth bead surface, self releasing slag. Surfacing in 1 - 2 or eventual 3 layers for all pieces subject to high abrasion combined with a good resistance to shocks. Only machinable by grinding.

Applications

For Excavating and Crashing equipment, Surfacing of endless screws, Mixer blades, Pump bodies for abrasive materials, Excavator teeth, Crashing installations for Minerals, Concrete pumps, Ores crushing, Ploughshares, Lumps break, Screw presses for bricks.

Typical Weld Metal Composition (%)

C	Si	Mn	Cr	Fe
3.30	1.00	0.50	29.00	base

All Weld Metal Mechanical Properties (Typical)

Hardness 1 st layer (HRC)	Hardness on pure weld metal
AW	HRC
58	60

Welding Current & Instructions

Electrode	Ø x L (mm)	2.5 x 350	3.2 x 350	4.0 x 450	5.0 x 450
Current	(Amp)	80 - 90	120 - 130	150 - 160	200 - 210

Redrying of electrode at 250°C for 1hr before use, if necessary. Guide electrode almost vertically with a short arc. In case of hardfacing high alloyed steels like stainless steels. It is recommended to apply a cushion layer with selectarc 29/9 or 18/8Mn.



1G/PA

= + ~ 50 V

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