



SELECTARC HB64S

Coated Electrode for Surfacing in Sugar Mills

Classification

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

Characteristics

Electrodes with a high alloy content of elements which form carbides. Therefore especially used for hard facing of parts subject to high abrasion, friction and corrosion. The electrode is easy to weld, has a smooth drop transfer and only a negligible slag content, easy restriking even on wet pieces. Recovery approx. 200%.

Applications

Especially designed for Claddings in sugar mills, Roughing or arcing of mill rollers for better gripping etc.

Typical Weld Metal Composition (%)

C	Si	Mn	Cr	Fe
4.00	2.00	2.00	25.00	base

All Weld Metal Mechanical Properties (Typical)

Hardness (HRC)

AW

61

Welding Current & Instructions

Electrode	∅ x L (mm)	3.2 x 350	4.0 x 450	5.0 x 450
Current	(Amp)	120 - 140	170 - 210	220 - 260

Maintain a short arc and hold the electrode almost vertical. Select lowest amperage possible to keep dilution low and weave only slightly.



1G/PA



2F/PB



2G/PC



3G/PF



4G/PE

= + ~ 50 V

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