Selectarc WELDING

SELECTARC HBC62

Hardfacing Electrode for Cutting Tools

Classification

DIN 8555 : E4-UM-60-ST
EN 14700 : E Fe4
AWS A5. 13 : ~EFe5 - B

Characteristics

Rutile-basic coated electrode is recommended to surface all kinds of cutting tools, such as lathe and plane tools. The sharpness obtained has an exceptional quality. C-Cr-Mo-W martensitic deposit, resistant upto 500°C. This electrode is also used for surfacing of pieces subject to metal/metal wear. Withstands moderate shock. In as welded condition only machinable by grinding. For Machining by tools, carry out a after soft annealing heat treatment at 850°C for 2 hours followed by slow cooling (approx. 3°C/min.) in an oven. In order to re-obtain the hardness, temper the deposit at 1200°C/ 1hr, cooling in oil or with compressed air and annealing 2 x 500°C.

Applications

Hardfacing of Machining tools, Cutting tools made of steel, Punches, Drills, Shear blades.

Typical Weld Metal Composition (%)

C	Si	Mn	Cr	Mo	V	W	Fe
0.80	0.50	0.50	5.00	10.00	1.50	1.50	base

All Weld Metal Mechanical Properties (Typical)

Hardness (HRC)

AW (Obtained on pure weld metal)

60 - 63

Welding Current & Instructions

Electrode	ØxL (mm)	2.5 x 350	3.2 x 350	4.0 x 450
Current	(A)	70 - 80	100 - 110	140 - 150

Redrying of electrode at 250°C for 1hr before use, if necessary. 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.

= +	~ 50 V

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