



Selectarc B92

*Alloy C type Electrode
For surfacing*

Description & Applications

Special surfacing electrode with 170% recovery and a deposit composition of alloy C (Ni-Cr-Mo-W) with Co<1%. Rutile-basic coating with outstanding welding characteristics. Deposit resists to corrosion in presence of chloride acid (up to 160°C) and in general to all type of oxidation. Deposit work-hardens under impact and is machinable. B92 is destined in general to surface all pieces subject to mechanical stress combined with corrosion and/or high temperatures (from 400-750°C). Also used for pieces subject to high thermal shocks.

General applications: Surfacing of hot working tools as hot shear blades, deburring tools, swages, dies, press tools as well as pump parts, installations for chlorisation, valves and reservoirs.

All Weld Metal Mechanical Properties

Hardness (as welded)	Hardness (work-hardened)
~250 HB	350-400 HB

Welding Current & Instructions

Electrode	ØxL (mm)	2,5x350	3,2x350	4,0x350
Current	(A)	75	110	135

Pieces to surface must be clean. When there is a build up of important thickness, carry out a cushion layer with Selectarc B90 electrodes. Preheat massive parts at 300 to 500°C following their composition and keep the temperature during welding. Then, slow cooling.

FT En-641-250115



= + ~ 70V

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