



# Selectarc HB40

*Surfacing Electrode*

## Description & Applications

Rutile coated electrode for surfacing of machine and construction parts, as well as of tools made of low-alloyed and cast steels which are mainly stressed by pressure and shock. Electrodes are easy to weld even on small welding equipment with low open arc voltage. Soft flow, almost no spatters, self releasing slag, nice aspect of the weld beads. Sound, crack free deposit, machinable with carbide cutting tools.

**General applications:** Surfacing of rollers, gear teeth, stamps, hammers, guide rails etc.

## All Weld Metal Mechanical Properties

Hardness

~ 400 HB ; 39-42 HRC

Obtained in pour weld metal

## Welding Current & Instructions

Electrode	ØxL ( mm )	2,5x350	3,2x450	4,0x450
Current	( A )	90	115	160

Redrying 1h at 150°C, if necessary. Preheating is not required on mild and medium carbon steels. Low alloyed, high carbon tool steels etc. have to be preheated to 250-400°C, depending on their composition and thickness. Slow cooling in still air after surfacing.

ind.13



= - ~ 45V

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