



Selectarc HB60

Rutile Electrode for hardfacing

Description & Applications

Rutile-basic coated electrode for surfacing of machine and construction parts, as well as of tools made of low-alloyed and cast steels, resistant to medium abrasion, shock and pressure. Air hardening deposit, good compromise between resistance to abrasion and resistance to 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 by grinding.

General applications: Hardfacing of moulds, scrapers, buckets and bucket teeth, excavator parts, chisels, conveyer screws, track links, cutting tools, crusher cones.

All Weld Metal Mechanical Properties

Hardness

~ 600 HB ; 55-60 HRC

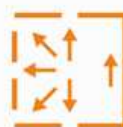
Obtained in pour weld metal, 2-3 layers

Welding Current & Instructions

Electrode	ØxL (mm)	2,5x350	3,2x450	4,0x450	5,0x450
Current	(A)	90	115	160	230

Redrying 1h at 150°C, if necessary. For substantial build up on highly alloyed steels, like tool steels, a cushion layer with selectarc 29/9 or 18/8Mn is recommended. Low alloyed, high carbon tool steels etc. have to be preheated to 250-400°C, depending on the ir composition and thickness. Slow cooling in still air after surfacing.

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