



Selectarc HB63

High efficiency Electrode for hardfacing

Description & Applications

Synthetic rutile coated hardfacing electrode with high recovery (160%). For applications subject to abrasive wear by minerals, combined with medium impact and compression. Austenitic matrix containing Cr carbides. The deposit resists to corrosion due to the high chromium content as well as heat up to 200°C. Easy flow, smooth bead surface, self releasing slag. Surfacing in 1 - 2 or eventual 3 layers for all pieces subject to high abrasion combined with a good resistance to shocks. Only machinable by grinding.

General applications: For excavating and crashing equipment, surfacing of endless screws, mixer blades, pump bodies for abrasive materials, excavator teeth, crashing installations for minerals, concrete pumps, ores crushing, ploughshares, lumps break, screw presses for bricks

All Weld Metal Mechanical Properties

Hardness 1st layer
~ 58 HRC

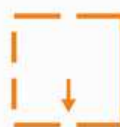
Hardness all weld metal
~ 60 HRC

Welding Current & Instructions

Electrode	ØxL (mm)	2,5x350	3,2x350	4,0x450	5,0x450
Current	(A)	90	130	160	210

Redrying 1h at 250°C, if necessary. Guide electrode almost vertically with a short arc. In case of hardfacing high alloyed steels like stainless steels, it is recommended to apply a cushion layer with selectarc 29/9 or 18/8Mn.

ind.13



= + ~ 50V

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