



Selectarc HB68Nb

*Hardfacing Electrode
Against high mineral abrasion*

Description & Applications

Basic coated, almost slag free, hardfacing electrode with high recovery (230%). Highly resistant to abrasion due to its high content of Cr and other Carbide forming elements. The service life of surfaced pieces is up to 5 times longer than for conventional Chrome-Carbide electrodes. For hard-facing apply one or maximum two layers. Resists to heavy mineral abrasion and moderate impact. Only machining by grinding. Regular top transfer, no slag, smooth beads. The formation of cracks in the weld deposit is normal for this type of composition. For all pieces subject to low or moderate shock where an important resistance to abrasion is searched.

General applications: For endless screws, mixer paddles, pump bodies for abrasive materials, excavator teeth, concrete pumps, screws for brick presses, brick moulds, pressing dies.

All Weld Metal Mechanical Properties

Hardness

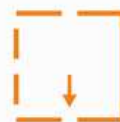
~64 HRC obtained in 1st layer

Welding Current & Instructions

Electrode	ØxL (mm)	3,2x350	4,0x450	5,0x450
Current	(A)	140	180	220

Redrying 1h at 250°C, if necessary. Hold a short arc and guide the electrode steep, only with a slight inclination against the vertical. Select low amperage giving still a stable arc and weave only slightly to keep the dilution with the base material low and to get a high hardness already in the first layer.

ind.13



= + ~ 70V

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