



HBC63

*Hardfacing Electrode
For cutting tools*

Description & Applications

High recovery- 140% Rutile-basic coated electrode destined to surface all kinds of cutting tools such as lathe and plane tools. The sharpness obtained has an exceptional quality. Martensitic deposit, alloyed with C-Cr-W-Mo-Co, resistant up to 550°C. This electrode is also used for surfacing of pieces subject to metal/metal wear. Withstands moderate shock. In the as welded condition only machinable by grinding.

Special applications: Hardfacing of cutting tools for tire recycling, shear blades made of steel, punches, drills.

All Weld Metal Mechanical Properties

Hardness

61-65 HRC

Obtained in pour weld metal, untreated

Welding Current & Instructions

Electrode	ØxL (mm)	2,5x350	3,2x350	4,0x450
Current	(A)	90	120	150

Redrying 1h at 250°C, if necessary. Low alloyed, high carbon tool steels etc. have to be preheated to 250-450°C, depending on their composition and thickness. Slow cooling in still air after surfacing.

ind.13



= + ~ 50V

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