Selectarc HBMAX

Hardfacing Electrode - High Temperatures

Description & Applications

The weld deposit resists against metal to metal wear , corrosion and high temperatures. Therefore the electrode is used for overlay and build up of machinery parts and tools subject to impact, compression and wear, used at operating temperatures up to 650°C. The deposit is resistant to thermal shock and can be machined with tungsten carbide tipped tools. Rutile-basic coated electrode with a stable arc, regular drop transfer and a smooth deposit.

General applications: For building up dies, for hot working tools, for moulds, continuous driving rolls, mandrels, forming tools, ...

Base materials

High strength carbon steels, tool steels and hot working steels

Material N°	DIN classification	Material N°	DIN classification
1.2311	40CrMnMo 7	1.2367	X38CrMoV 5 3
1.2343	X38CrMoV 5 1	1.2606	X37CrMoW 5 1
1.2344	X40CrMoV 5 1	1.2713	55NiCrMoV 6
1.2365	X32CrMoV 3 3	1.2714	56NiCrMoV 7

All Weld Metal Mechanical Properties

Hardness (as welded)	After work hardening
45-50 HRC	Up to 55 HRC

Welding Current & Instructions

Electrode	ØxL (mm)	2,5x300	3,2x350	4,0x450
Current	(A)	60-90	90-120	110-150

Redrying 2h at 300°C, if necessary. Clean weld zone properly. Preheat massive work pieces to 150-400°C, depending on the composition. Hold the electrode vertically with a short arc. Keep temperature during welding and let the work piece cool slowly.

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