



Selectarc HRT68

*Tubular Electrode
Against extreme abrasion*

Description & Applications

Tubular electrode filled with W and Cr carbides. Deposit highly resistant to abrasion without impact (or moderate shocks). Essentially composed of W carbides (exceptional resistance to abrasion). Stainless matrix, excellent friction coefficient, agreeable melting, no slag, deposit not machinable. Possibility to increase the deposition rate by introducing a second electrode in the arc (double the recommended intensity). Surfacing of all austenitic steels, cast iron, tool steels or highly alloyed steels (in this case, carry out a cushion layer with Selectarc 29/9 or 18/8Mn electrodes). Mainly destined to pieces subject to a high mineral abrasion and to temperature up to 300°C.

General applications: Material of civil engineering, agriculture, quarries, mines, (mixer, blade, conveyer screws, ...)

All Weld Metal Mechanical Properties

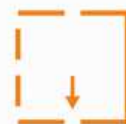
Hardness
64-68 HRC

Welding Current & Instructions

Electrode	ØxL (mm)	6x450	8x450	12x450
Current	(A)	80-120	120-180	210-250

Maintain an arc length of 2 to 5mm, weave with the electrodes. Hold the electrode perpendicularly to the surface. Do not apply more than 2 or 3 layers.

ind.13



= + ~ 45V

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