Selectarc B92Co

Hardfacing Electrode
Thermal shock resistant

Description & Applications

Special hardfacing electrode with 170% recovery and a deposit composition of alloy C (Ni-Cr-Mo) + Co. Rutile-basic coating with outstanding welding characteristics. Deposit resists against corrosion, scaling, oxidation and thermal shocks. It is machinable. Selectarc B92Co is used to surface parts subject to compression, corrosion, high temperatures (400-800°C) as well as thermal shocks. This electrode has a higher hot strength and is more resistant against thermal shocks and metallic abrasion compared to Selectarc B 92.

General applications: Surfacing of hot working tools, as hot shear blades, deburring tools, swages, forging saddles, forging and hot trimming dies, press tools as well as pump parts.

All Weld Metal Mechanical Properties

Hardness (as welded)	Hardness (work-hardened)
~250 HB	350-400 HB

Welding Current & Instructions

Electrode	ØxL (mm)	2,5x350	3,2x350	4,0x350
Current	(A)	75	110	135

For heavier overlays use only for the last two cover passes. For intermediate layers use Selectarc B90 electrodes. Keep amperage low, preheat heavy workpieces to 300-500° C. Guide electrodes steep, keep arc short, and prevent accesive weaving. Workpiece should be kept at temperature during surfacing and then cooled down slowly.

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= +	~ 70V

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