Selectarc HB40HT

Basic Coated Electrode
For hot working tools

Description & Applications

Basic electrode for hardfacing. The weld deposit distinguishes itself by its toughness and heat resistance. Used for overlay and builds up of machinery parts and tools subject to impact, compression and wear used at operating temperatures up to 550°C.

General applications: For building up dies, rollers, hot shear blades,...

Base materials **High strength carbon 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)
38-42 HRC
Obtained in pour weld metal

Welding Current & Instructions

Electrode	ØxL (mm)	2,5x300	3,2x350	4,0x450
Current	(A)	60-90	80-110	100-140

Preheat the workpiece to 250-400°C depending on thickness and alloy. Hold the electrode vertically with a short arc. Keep temperature during welding and let the workpiece cool slowly. Subsequent machining is possible by grinding or with tungsten carbide tools.

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