# Selectarc HB48HT

*Basic Coated Electrode*
*For hot working tools*

## Description & Applications

The weld deposit distinguishes itself by its toughness and heat resistance. Therefore the electrode is 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.It is widely used for building up hammers, dies, swages, hot shear blades, rollers, …

**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 )
45-50 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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| = +,- | ~ 70V |
|---|---|

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