Selectarc HB600HT

Hardfacing Electrode
For metal/metal wear

Description & Applications

Rutile coated electrode with a Cr-Mo-C martensitic steel deposit, resistant to metal/ metal wear up to 550°C. For all pieces subject to hot or cold metal abrasion, even in the presence of shocks and pressure. As welded only machinable by grinding. Soft fusion, no spatters, self releasing slag.

General applications: Hardfacing of shear blades, moulds, pressing and forging dies.

All Weld Metal Mechanical Properties

Hardness
58–61 HRC
Obtained in pour weld metal

Welding Current & Instructions

Electrode	ØxL (mm)	2,5x350	3,2x350	4,0x450
Current	(A)	80	110	150

Redrying 1h at 250°C, if necessary. Low alloyed, high carbon tool steels etc. have to be preheated to 250-450°C, depending on their composition and thickness. Slow cooling in still air after surfacing.

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= +	~ 45V

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