Selectarc HB61R

Hardfacing Electrode resistant to Impact, compression and abrasion

Description & Applications

Rutile-basic coated general purpose hardfacing electrode for applications subject to impact, compression and abrasive wear. For hardfacing on components made of C-steel, cast steel and Manganese steel. The deposit is tough-hard and crack resistant. Recovery of the electrode approx. 120%.

General applications: Hardfacing of block presses, crusher jaws, wheel rims, rollers, caterpillar tracks, ploughshares, running surfaces, cutting edges etc...

All Weld Metal Mechanical Properties

Hardness
~60 HRC
Obtained in pour weld metal

Welding Current & Instructions

Electrode	ØxL (mm)	2,5x350	3,2x350	4,0x450
Current	(A)	60-90	90-120	110-160

Redrying, if necessary, 2h/300°C. Guide electrode almost vertically with a short arc. On materials sensitive to cracks a buffer-layer with selectarc 18/8Mn is recommended. Low alloyed, high carbon tool steels etc. have to be preheated to 200-400°C, depending on their composition and thickness. Slow cooling in still air after surfacing.

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= +	~ 50V

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