Selectarc HB64S

Coated Electrode for Surfacing
In sugar mills

Description & Applications

Electrodes with a high alloy content of elements which form carbides. Therefore especially used for hard facing of parts subject to high abrasion, friction and corrosion. The electrode is easy to weld, has a smooth drop transfer and only a negligible slag content, easy re-striking even on wet pieces. Recovery approx. 200%.

General applications: Especially designed for claddings in sugar mills , roughing or arcing of mill rollers for better gripping etc.

All Weld Metal Mechanical Properties

Hardness
~ 61 HRC

Welding Current & Instructions

Electrode	ØxL (mm)	3,2x350	4,0x450	5,0x450
Current	(A)	120-150	170-210	220-260

Hold a short arc and the electrode almost vertical. Select lowest amperage possible to keep dilution low and weave only slightly.

ind.13



= +	~50V

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