Selectarc HB95CoB

Hardfacing Electrode
For hot forging

Description & Applications

Special basic coated hardfacing electrode with 150% recovery and a deposit composition of alloy UD520. Deposit resists corrosion, scaling, oxidation and thermal shocks. It offers a high temperature strength and is machinable. Selectarc HB95CoB is used to surface parts subject to metal-metal wear at high temperatures, combined with heavy impacts, compression, as well as thermal shocks.

General applications: Surfacing of dies, hot working dies, swages, press tools as well as hot rolls.

All Weld Metal Mechanical Properties

Hardness (as welded)	Hardness (work-hardened)
~220 HB	~350 HB

Welding Current & Instructions

Electrode	ØxL (mm)	2,5x350	3,2x350	4,0x350
Current	(A)	90	120	150

For heavier overlays use HB95CoB only for the last three cover passes. For intermediate and build up layers use Selectarc Ni82 and B92Co. Keep amperage low, preheat heavy work-pieces to 300-500° C. Guide electrodes steep, keep arc short, prevent excessive weaving. Work-piece should be kept at temperature during surfacing and then cooled down slowly. Don't overheat the electrode weld with the lowest practical amperage.

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