Selectarc HRT60

Tubular Electrode
For hardfacing
(mineral abrasion)

Description & Applications

Tubular electrode filled with chromium carbide powder. Deposit highly resistant to abrasion and mineral erosion. High amount of Cr carbides in an austenitic matrix, very compact. To consume with very low current. Agreeable melting. No slag. Deposit not machinable. Possibility to increase deposition by introducing a second electrode in the arc (double the recommended current). Surfacing of all austenitic and Mn steels types, grey cast iron (without any preheating), tool steels or high alloyed steels (in this case, carry out a cushion layer with Selectarc 29/9 or 18/8Mn electrodes).

General applications: For agriculture, cement industries, quarries, brickyards, civil engineering, for screws of brick press, for excavating jars,...

All Weld Metal Mechanical Properties

Hardness (1st layer)	Hardness (2nd layer)
55-60 HRC	58-62 HRC

Welding Current & Instructions

Electrode	ØxL (mm)	6x450	8x450	12x450
Current	(A)	80-120	120-180	210-250

Maintain an arc length of 2 to 5 mm, weave with the electrodes. Hold the electrode perpendicularly to the surface. Do not apply more than 2 or 3 layers.

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= +	~ 45V

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