Selectarc HRT63

Tubular Electrode
For Hardfacing
(abrasion + impact)

Description & Applications

Tubular electrode filled with metal powders (carbides of Cr and Nb). This electrode produces a deposit characterised by an exceptional hardness and resistance to abrasion, combined with moderate impact. Higher resistant than conventional electrodes (because of the low dilution with the base metal). Deposit essentially composed of complex carbides of Cr and Nb, in an austenitic matrix. Good resistance to mineral abrasion and impact due to the very fine presence of Nb carbides. Rust proof deposit resists to temperature up to 300°C. Use with low current. No slag, only machinable by grinding, possibility to increase the deposition rate by introducing a second electrode in the arc (in this case, double the recommended current). Surfacing of C steels, of grey cast iron without buffer layer, alloyed steels and tool steels (in this case, carry out a cushion layer with Selectarc 29/9 or 18/8 Mn electrodes).

General applications: For civil engineering, cement industries, agriculture for press screws, mixing blades, jars teeth and blades, jars teeth and blades, scrapers, crushing hammers, sieving gates, excavator teeth...

All Weld Metal Mechanical Properties

Hardness (1st layer)	Hardness (2nd layer)
57-60 HRC	60-64 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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