



# Selectarc B92

*Alloy C type Electrode  
For surfacing*

## Description & Applications

Special surfacing electrode with 170% recovery and a deposit composition of alloy C (Ni-Cr-Mo) Rutile-basic coating with outstanding welding characteristics. Deposit resists to corrosion in presence of chloride acid (up to 160°C) and in general to all type of oxidation. Deposit work-hardens under impact and is machinable. B 92 is destined in general to surface all pieces subject to mechanical stress combined with corrosion and/or high temperatures (from 400 - 750°C). Also used for pieces subject to high thermal shocks.

**General applications:** Surfacing of hot working tools as hot shear blades, deburring tools, swages, dies, press tools as well as pump parts, installations for chlorisation, valves and reservoirs.

## All Weld Metal Mechanical Properties

Hardness (as welded)	Hardness (work-hardened)
~250 HB	350-400 HB

## Welding Current & Instructions

Electrode	ØxL ( mm )	2,5x350	3,2x350	4,0x350
Current	( A )	75	110	135

Pieces to surface must be clean. When there is a build up of important thickness, carry out a cushion layer with Selectarc B90 electrodes. Preheat massive parts at 300 to 500°C following their composition and keep the temperature during welding. Then, slow cooling.

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= +	~ 70V
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