



Selectarc HB25

Surfacing Electrode

Description & Applications

Rutile coated electrode for surfacing of equipment parts, constructions and tools, resistant to medium friction and compression. Good resistance to cavitation, highly resistant to shocks. Sound, crack free deposit, machinable with standard tools.

General applications: Surfacing of rails and switches, roller guides, slideways, build up before hardfacing.

All Weld Metal Mechanical Properties

Hardness
~ 250 HB
Obtained in pour weld metal

Welding Current & Instructions

| Electrode | ØxL (mm) | 2,5x350 | 3,2x450 | 4,0x450 | 5,0x450 |
|-----------|------------|---------|---------|---------|---------|
| Current | (A) | 90 | 115 | 160 | 230 |

Preheating is not required on mild and medium carbon steels. Low alloyed, high carbon tool steels etc. have to be preheated to 200-400°C, depending on their composition and thickness. Slow cooling in still air after surfacing.

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= - ~ 45V

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