



Selectarc HB300B

*Semi-hard machinable
Surfacing Electrode*

Description & Applications

Basic coated electrode semi-hard, machinable and tough with approx. 120% recovery for surfacing on equipment parts and tools. Resisting to medium friction and compression - highly resistant to shocks - dense deposit and free of cracks. Soft fusion - low spatters - self releasing slag - nice aspect of the beads.

General applications: For heavy build up and as cushion layer on forging die cavities, mandrels, gear teeth, chains, sprockets, punches, blades, drawing dies.

All Weld Metal Mechanical Properties

Hardness

~ 300 HB

Obtained in pour weld metal

Welding Current & Instructions

Electrode	ØxL (mm)	3,2x350	4,0x450	5,0x450
Current	(A)	80-110	110-140	140-180

Redrying 2h at 250°C, if necessary. 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.

Ind.13



= + ~ 70V

Liability: This document is intended to assist the user in choosing the product. It is up to the user to verify that the chosen product is suitable for applications for which it is intended. The company FSH Welding Group reserves the right to alter specifications without prior notice of its products. The descriptions, illustrations and specifications are for reference only and cannot be held liable for FSH Welding Group. **Fumes:** Consult information on MSDS, available upon request.