



Selectarc HB450HT

*Hardfacing Electrode
For metal wear*

Description & Applications

Rutile coated electrode with a martensitic steel deposit containing fine carbides of W, Cr and V. The principal property of the deposit is its resistance to metal/ metal wear up to 550°C. The deposit is only machinable after soft annealing at 750 – 800°C / 4 hours, followed by slow cooling in an oven. In order to obtain a hardness of 50HRC the deposit can be tempered after machining (1100°C/ oil or compressed air). Can be used for reclaiming, a final pass using HB600HT is often recommended. Soft fusion, no spatters, self releasing slag.

General applications: Hardfacing of trimming and blanking dies, of shear blades, of cold and hot working dies of punches, hot shearing knives, forging dies...

All Weld Metal Mechanical Properties

Hardness (as welded)	Soft annealed, 750-800°C	Hardened 1100°C/oil
40-45 HRC	20-25 HRC	50 HRC

Welding Current & Instructions

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

Redrying, if necessary, 1h/250°C. Low alloyed, high carbon tool steels etc. have to be preheated to 250-450°C, depending on their composition and thickness. Slow cooling in still air after surfacing.

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= +	~ 50V
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