



Selectarc HBC62

*Hardfacing Electrode
For cutting tools*

Description & Applications

Rutile-basic coated electrode destined to surface all kinds of cutting tools such as lathe and plane tools. The sharpness obtained has an exceptional quality. C-Cr-Mo-W martensitic deposit, resistant up to 500°C. This electrode is also used for surfacing of pieces subject to metal/metal wear. Withstands moderate shock. In the as welded condition only machinable by grinding. For machining by tools, carry out a soft annealing heat treatment at 850°C during 2 hours followed by slow cooling (approx. 3°C/min.) in an oven. In order to re-obtain the hardness, temper the deposit: 1200°C/ 1h, cooling in oil or with compressed air and annealing 2x500°C.

General applications: Hardfacing of machining tools, cutting tools made of steel, punches, drills, shear blades.

All Weld Metal Mechanical Properties

Hardness

60-63 HRC

Obtained in pour weld metal, untreated

Welding Current & Instructions

| | | | | |
|-----------|------------|---------|---------|---------|
| Electrode | ØxL (mm) | 2,5x350 | 3,2x350 | 4,0x450 |
| Current | (A) | 80 | 110 | 150 |

Redrying 1h at 250°C, if necessary. 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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