



HBC63

Hardfacing Electrode
For cutting tools

Description & Applications

High recovery- 140% 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. Martensitic deposit, alloyed with C-Cr-W-Mo-Co, resistant up to 550°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.

Special applications: Hardfacing of cutting tools for tire recycling, shear blades made of steel, punches, drills.

All Weld Metal Mechanical Properties

Hardness

61-65 HRC

Obtained in pour weld metal, untreated

Welding Current & Instructions

Electrode	ØxL (mm)	2,5x350	3,2x350	4,0x450
Current	(A)	90	120	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.

ind.13



= + ~ 50V

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.