

***selectarc***  
**HRT60WC**

**Tungsten Carbide Electrode  
against extreme abrasion**



**Classification**

DIN 8555 : E 21-UM-65-G  
EN 14700 : E Fe20

**Description & Applications**

Tubular electrode filled with Tungsten carbides. Deposit highly resistant to abrasion without impact. Steel matrix with a high amount of tungsten carbides and an exceptional resistance to scraping abrasion . The electrode has a smooth fusion and a stable arc, the slag is easy to remove, the weld deposit is not machinable.

Surfacing of parts which are subject to extremely mineral abrasion in agriculture, earth moving, mining and steel industry. For concrete and sand mixer blades, conveyer screws, brick dies, shredder knives, etc. .

Apply 1 or maximum 2 layers.

General applications: material of civil engineering, agriculture, quarries, mines; for mixer blades , conveyer screws, plough shares, ...

**Typical Weld Metal Composition ( % )**

WC/W <sub>2</sub> C	Fe
65	base

**All Weld Metal Mechanical Properties**

Hardness  
64-68 HRC

**Welding Current & Instructions**

Electrode	ØxL ( mm )	4x350
Current	( A )	90-120

Keep the arc short , weave with the electrodes. Hold the electrode perpendicularly to the surface. Do not apply more than 2 layers.



1G/PA

= + ~ 45V



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