Selectarc **B92** AC/DC+ **NICKEL ALLOY**

DESCRIPTION

Hastelloy C type Electrode for surfacing. Special surfacing electrode with 170 % recovery and a deposit composition of Hastelloy C (Ni-Cr-Mo) rutile-basic coating with outstanding welding characteristics. Deposit resists to corrosion in presence of chloride acid (up to 160°C (320°F)) and in general to all type of oxidation. Deposit work-hardens under impact and is machinable. **Selectarc B92** is destined in general to surface all pieces subject to mechanical stress combined with corrosion and/or high temperatures (from 400 - 750°C) (752 - 1382°F). Also used for pieces subject to high thermal shocks.

CLASSIFICATION

AWS A5.11 : ENiCrMo-5 DIN 8555 : E23-UM-250-CKTZ EN 14700 : E Ni2

TYPICAL APPLICATIONS

Surfacing of hot working tools as hot shear blades, deburring tools, swages, dies, press tools as well as pump parts, installations for colorization, valves and reservoirs.
Note : ''Hastelloy'' is a registered trade mark of Haynes international

PROCEDURE

Pieces to surface must be clean. When there is a build up of important thickness, carry out a cushion layer with **Selectarc B 90** electrodes. Preheating can be necessary. Cool slowly.

MECHANICAL PROPERTIES

Hardness (as-welded): ~ 25 HRC
Hardness (work-hardened): ~ 38 - 43 HRC

TYPICAL WELD METAL COMPOSITION (%)

C	Mn	Si	Cr	Mo	W	Fe	Ni
< 0.10	0.8	0.50	16.0	16.0	4.0	5.5	bal. (>56%)

WELDING PARAMETERS

Diameter:	4.0 mm (5/32")	3.2 mm (1/8")	2.5 mm (3/32")
Amperage:	135 A	110 A	75 A

WELDING POSITIONS

1G/PA 2F/PB

Rev.: 21_08

Specialized welding alloys and technology. For technical assistance or for ordering:

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