


**HB 25 AC/DC-**
**BUILD-UP**
**DESCRIPTION**

Rutile coated electrode for surfacing of equipment parts, constructions and tools, resistant to medium friction and compression. Good resistance to cavitation, highly resistant to shocks. Crack free deposit, machinable with standard tools.

**CLASSIFICATION**

DIN 8555 : E1-UM-250

EN 14700 : E Fe1

**TOTAL ALLOY CONTENT:** 3 % (Carbon, Silicon, Manganese, Chromium)

**TYPICAL APPLICATIONS**

Surfacing of rails and switches, roller guides, slideways, build-up before hardfacing.

**PROCEDURE**

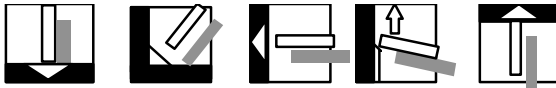
Preheating is not required on mild and medium carbon steels. Low alloyed, high carbon tool steels etc. have to be preheated to 200 - 400°C (392 - 752° F), depending on their composition and thickness. Slow cooling in still air after surfacing.

**MECHANICAL PROPERTIES**

Hardness (as-welded): ~ 25 HRC  
 Deposit thickness: Unlimited

**WELDING PARAMETERS**

Diameter:	5.0 mm (3/16")	4.0 mm (5/32")	3.2 mm (1/8")
Amperage:	230 A	160 A	115 A

**WELDING POSITIONS**


1G/PA

2F/PB

2G/PC

3G/PF

4G/PE

Flux-cored wire also available: **Selectarc FC 25**

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