


**HB 300B AC/DC+**
**BUILD-UP**
**DESCRIPTION**

Basic **coated electrode semi-hard, machinable** and tough with approx. 120% recovery **for surfacing** on equipment parts and tools. Resisting to medium friction and compression - highly resistant to shocks - dense deposit and free of cracks. Soft fusion - low spatters - self releasing slag - nice aspect of the beads.

**CLASSIFICATION**    DIN 8555 : E1-UM-300-P    EN 14700 : ~E Fe1

**TOTAL ALLOY CONTENT**

6,5 % (Carbon, Silicon, Manganese, Chromium, Nickel, Molybdenum)

**TYPICAL APPLICATIONS**

Mainly used for heavy build up and as cushion layer on forging die cavities, mandrels, gear teeth, chains, sprockets, punches, blades, drawing dies.

**PROCEDURE**

Re-drying, if necessary 2h/150°C. 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, depending on their composition and thickness. Slow cooling in still air after surfacing.

**MECHANICAL PROPERTIES**

Hardness (as-welded):            30 - 32 HRC  
Deposit thickness:                Unlimited

**WELDING PARAMETERS**

Diameter:	4.0 mm (5/32")	3.2 mm (1/8")
Amperage:	110 – 140 A	80 - 110 A

**WELDING POSITIONS**


1G/PA    2F/PB    2G/PC    3G/PF    4G/PE

Also available in solid wire (MIG): **Soudotec M300**

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