

**HB 40 AC/DC-****BUILD-UP****DESCRIPTION**

Medium hardness rutile coated electrode for surfacing of machine and construction parts, as well as of tools made of low-alloyed and cast steels which are mainly stressed by pressure and shock. Electrodes are easy to weld even on small welding equipment with low open arc voltage. Soft flow, almost no spatters, self releasing slag, nice aspect of the weld beads. Crack free deposit, machinable with carbide cutting tools. Deposits can be flame cut.

CLASSIFICATION: DIN 8555 : E1-UM-400 EN 14700 : E Fe1

TOTAL ALLOY CONTENT: 4 % (Carbon, Silicon, Manganese, Chromium)

TYPICAL APPLICATIONS

Surfacing of rollers, gear teeth, stamps, hammers, guide rails, etc.

PROCEDURE

Preheating is not required on mild and medium carbon steels. Low alloyed, high carbon tool steels etc. have to be preheated to 250-400°C, depending on their composition and thickness. Slow cooling in still air after surfacing.

MECHANICAL PROPERTIES

Hardness (as-welded): 39 - 42 HRC
Deposit thickness: Unlimited

WELDING PARAMETERS

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

WELDING POSITIONS

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

Flux-cored wire also available: **Selectarc FC 40**

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