



# HB 60 AC/DC-

## HARDFACING

### DESCRIPTION

**Rutile-basic coated electrode for surfacing** of machine and construction parts, as well as of tools made of low-alloyed and cast steels, resistant to medium abrasion, shock and compression. Air hardening deposit, good compromise between resistance to abrasion and resistance to 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 by grinding.

**CLASSIFICATION :** DIN 8555 : E2-UM-60      EN 14700 : E Fe2

**TOTAL ALLOY CONTENT:** 8 % (Carbon, Silicon, Manganese, Chromium, Iron)

### TYPICAL APPLICATIONS

Hardfacing of moulds, scrapers, buckets and bucket teeth, excavator parts, chisels, conveyer screws, track links, cutting tools, crusher cones.

### PROCEDURE

Redrying, if necessary, 1h/150°C. For hardfacing where more than 3 passes are necessary, apply a cushion layer with a electrode type **Selectarc HB 14Mn** or **Selectarc HB MnCr**. Low alloyed, high carbon tool steels etc. must be preheated to 250 - 400°C, depending on their composition and thickness. Slow cooling in still air after surfacing.

### MECHANICAL PROPERTIES

Hardness (as-welded):                    55 - 60 HRC  
Deposit thickness:                        2 - 3 passes maximum

### 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 60**

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