


HB 63 AC/DC+

HARDFACING

DESCRIPTION

Synthetic rutile **coated hardfacing electrode with high recovery** (160%). For applications subject to abrasive wear by minerals, combined with medium shocks and compression. Austenitic matrix containing Cr carbides. Deposit resists to corrosion due to the high chromium content as well as heat up to 200°C (392°F). Easy flow, self releasing slag. Surfacing in 1 or 2 layers for all pieces subject to high abrasion combined with a good resistance to shocks. Only machinable by grinding.

CLASSIFICATION : DIN 8555 : E10-UM-60-GRPZ EN 14700 : E Fe14

TOTAL ALLOY CONTENT: 38 % (Carbon, Silicon, Manganese, Chromium, Iron)

TYPICAL APPLICATIONS

For excavating and crashing equipment, surfacing of endless screws, mixer blades, pump bodies for abrasive materials, excavator teeth, crashing installations for minerals, concrete pumps, ores crushing, ploughshares, lumps break, screw presses for bricks.

PROCEDURE

Guide electrode almost vertically with a short arc. For hardfacing where more than 2 passes is necessary, apply a cushion layer with a electrode type **Selectarc HB 14Mn** or **Selectarc HB MnCr**. 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 (1st layer): ~ 58 HRC
 Hardness (all weld metal): 61 - 63 HRC
 Deposit thickness: 1 - 2 passes maximum

WELDING PARAMETERS

Diameter:	5.0 mm (3/16")	4.0 mm (5/32")	3.2 mm (1/8")
Amperage:	210 A	160 A	130 A

WELDING POSITIONS



1G/PA

Flux-cored wire also available: **Selectarc FC 63**

Rev.: 21_08

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

FSH WELDING Canada

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