


HB 65 AC/DC+

HARDFACING
DESCRIPTION

Electrodes with a **high alloy content of elements which form carbides**. Therefore, especially used for hardfacing of parts subject to high abrasion, friction, heat at operation temperatures up to 450°C (842°F) and corrosion. The electrode is easy to weld, has a smooth drop transfer and only a negligible slag content. Recovery approx. 190%.

CLASSIFICATION: DIN 8555: E10-UM-65-GR

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

TYPICAL APPLICATIONS

Ash plows, coke crusher segments, screw conveyers, valves, exhaust fans, agitator fingers, mill guides, mixer paddles, rake teeth in furnaces, tong bits, slag ladles, elevator bucket tips etc.

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: ~ 64 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:	190 – 250 A	140 - 190 A	130 – 150 A

WELDING POSITIONS


1G/PA

Flux-cored wire also available: **Selectarc FC 65**

Rev.: 21_08

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