


HRT 60 AC/DC+
HARDFACING
DESCRIPTION

Tubular electrode for hardfacing filled with chromium carbide powder. Deposit highly resistant to abrasion and mineral erosion. High amount of Cr carbides in a ferritic matrix, very compact. To consume with very low current. Agreeable melting. No slag. Deposit not machinable. Excellent in all-positions. Surfacing of all austenitic and Mn steels types, grey cast iron (without any preheating), tool steels or high alloyed steels (in this case, carry out a cushion layer with **Selectarc HB MnCr** electrodes).

CLASSIFICATION EN 14700 : E Fe15

TOTAL ALLOY CONTENT: 41 % (Carbon, Manganese, Chromium, Iron)

TYPICAL APPLICATIONS

Principally destined to agriculture, cement industries, quarries, brickyards, civil engineering, for screws of brick press, excavating jars, ...

PROCEDURE

Maintain an arc length of 2 to 5 mm, weave with the electrodes. Hold the electrode perpendicularly to the surface. Do not apply more than 2 layers.

MECHANICAL PROPERTIES

Hardness (1 st layer):	55 - 60 HRC
Hardness (2 nd layer):	58 - 62 HRC
Deposit thickness:	2 passes maximum

WELDING PARAMETERS

Diameter:	12.0 mm (1/2")	8.0 mm (3/8")	6.0 mm (1/4")
Amperage:	210 - 250 A	120 - 180 A	80 - 120 A

WELDING POSITIONS


1G/PA

Rev.: 21_08

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