



Selectarc HB300B

*Semi-hard machinable
Surfacing Electrode*

Description & Applications

Basic coated electrode semi-hard, machinable and tough with approx. 120% recovery for surfacing on equipment parts and tools. Resisting to medium friction and compression - highly resistant to shocks - dense deposit and free of cracks. Soft fusion - low spatters - self releasing slag - nice aspect of the beads.

General applications: For heavy build up and as cushion layer on forging die cavities, mandrels, gear teeth, chains, sprockets, punches, blades, drawing dies.

All Weld Metal Mechanical Properties

Hardness
~ 300 HB
Obtained in pour weld metal

Welding Current & Instructions

Electrode	ØxL (mm)	3,2x350	4,0x450	5,0x450
Current	(A)	80-110	110-140	140-180

Redrying 2h at 250°C, if necessary. Preheating is not required on mild and medium carbon steels. Low alloyed, high carbon tool steels etc. have to be preheated to 200-400°C, depending on their composition and thickness. Slow cooling in still air after surfacing.

Ind.13



= + ~ 70V

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