



# Selectarc HB48HT

*Basic Coated Electrode  
For hot working tools*

## Description & Applications

The weld deposit distinguishes itself by its toughness and heat resistance. Therefore the electrode is used for overlay and builds up of machinery parts and tools subject to impact, compression and wear used at operating temperatures up to 550° C. It is widely used for building up hammers, dies, swages, hot shear blades, rollers, ...

### Base materials

### High strength carbon steels and hot working steels

Material N°	DIN classification	Material N°	DIN classification
1.2311	40CrMnMo 7	1.2367	X38CrMoV 5 3
1.2343	X38CrMoV 5 1	1.2606	X37CrMoW 5 1
1.2344	X40CrMoV 5 1	1.2713	55NiCrMoV 6
1.2365	X32CrMoV 3 3	1.2714	56NiCrMoV 7

## All Weld Metal Mechanical Properties

Hardness (as welded )

45-50 HRC

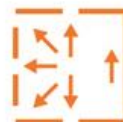
Obtained in pour weld metal

## Welding Current & Instructions

Electrode	ØxL ( mm )	2,5x300	3,2x350	4,0x450
Current	( A )	60-90	80-110	100-140

Preheat the workpiece to 250-400°C depending on thickness and alloy. Hold the electrode vertically with a short arc. Keep temperature during welding and let the workpiece cool slowly. Subsequent machining is possible by grinding or with tungsten carbide tools.

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= +,- ~ 70V



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