



Selectarc HB68

*Coated Electrode for
Hardfacing against high abrasion*

Description & Applications

Heavy coated electrode with a high alloy content of elements which form carbides. Therefore especially used for hardfacing of parts subject to high abrasion, moderate impact and temperature. The electrode is easy to weld, has a smooth drop transfer, only a negligible slag content and easy re-striking. Recovery approx. 240%.

General applications: For use in steel mills, on crushers, conveyor screws, dredger parts, sieves.

All Weld Metal Mechanical Properties

Hardness	Hot Hardness
~ 64 HRC on the 1 st layer	400°C: ~57 HRC 600°C: ~ 55HRC

Welding Current & Instructions

Electrode	ØxL (mm)	3,2x350	4,0x350
Current	(A)	130-150	160-190

Hold a short arc and the electrode almost vertical. Select lowest amperage possible to keep dilution low and weave only slightly.

ind.13



= +	~ 50V
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