

selectarc



HB 25

AC/DC-

BUILD-UP

DESCRIPTION

Rutile coated electrode for surfacing of equipment parts, constructions and tools, resistant to medium friction and compression. Good resistance to cavitation, highly resistant to shocks. Sound, crack free deposit, machinable with standard tools.

CLASSIFICATION

DIN 8555 : E1-UM-250

EN 14700 : E Fe1

TOTAL ALLOY CONTENT: 3 % (Carbon, Silicon, Manganese, Chromium)

TYPICAL APPLICATIONS

Surfacing of rails and switches, roller guides, slideways, build-up before hardfacing.

PROCEDURE

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 (392 - 752° F), depending on their composition and thickness. Slow cooling in still air after surfacing.

MECHANICAL PROPERTIES

Hardness (as-welded): ~ 25 HRC

Deposit thickness: Unlimited

WELDING PARAMETERS

Diameter:	5.0 mm (3/16")	4.0 mm (5/32")	3.2 mm (1/8")
Amperage:	230 A	160 A	115 A

WELDING POSITIONS



1G/PA



2F/PB



2G/PC



3G/PF



4G/PE

Flux-cored wire also available: **Selectarc FC 25**

Rev.: 7_01

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



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