

selectarc  **HB 300B** AC/DC+**BUILD-UP****DESCRIPTION**

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.

CLASSIFICATION DIN 8555 : E1-UM-300-P EN 14700 : ~E Fe1

TOTAL ALLOY CONTENT

6,5 % (Carbon, Silicon, Manganese, Chromium, Nickel, Molybdenum)

TYPICAL APPLICATIONS

Mainly used for heavy build up and as cushion layer on forging die cavities, mandrels, gear teeth, chains, sprockets, punches, blades, drawing dies.

PROCEDURE

Re-drying, if necessary 2h/150°C. 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.

MECHANICAL PROPERTIES

Hardness (as-welded): 30 - 32 HRC
Deposit thickness: Unlimited

WELDING PARAMETERS

Diameter:	5.0 mm (3/16")	4.0 mm (5/32")	3.2 mm (1/8")
Amperage:	140 - 180 A	110 - 140 A	80 - 110 A

WELDING POSITIONS

1G/PA



2F/PB



2G/PC



3G/PF



4G/PE

Also available in solid wire (MIG): **Soudotec M300**

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