

selectarc**HRT 60 WC**

AC/DC+

HARDFACING**DESCRIPTION**

Tubular electrode filled with Tungsten carbides. Deposit highly resistant to abrasion without impact. Steel matrix with a high amount of tungsten carbides and an exceptional resistance to scraping abrasion. The electrode has a smooth fusion and a stable arc, the slag is easy to remove, the weld deposit is not machinable. Surfacing of parts which are subject to extremely mineral abrasion in agriculture, earth moving, mining and steel industry. For concrete and sand mixer blades, conveyer screws, brick dies, shredder knives, etc.

CLASSIFICATION

DIN 8555 : E 21-UM-65-G

EN 14700 : E Fe20

TOTAL ALLOY CONTENT: 65 % WC / W₂C, Fe balance**TYPICAL APPLICATIONS**

Material of civil engineering, agriculture, quarries, mines, (mixer blades, conveyer screws ...)

PROCEDURE

Keep the arc short, weave with the electrode. Hold the electrode perpendicularly to the surface. Do not apply more than 2 layers.

MECHANICAL PROPERTIES

Hardness (as-welded): 64 - 68 HRC

Deposit thickness: 2 passes maximum

WELDING PARAMETERS

Diameter: 4.0 mm (5/32")

Amperage: 90 - 120 A

WELDING POSITIONS

1G/PA

Rev.: 7_01

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