

selectarc**HRT 60**

AC/DC+

HARDFACING**DESCRIPTION**

Tubular electrode for hardfacing filled with chromium carbide powder. Deposit highly resistant to abrasion and mineral erosion. High amount of Cr carbides in a ferritic matrix, very compact. To consume with very low current. Agreeable melting. No slag. Deposit not machinable. Excellent in all positions. Surfacing of all austenitic and Mn steels types, grey cast iron (without any preheating), tool steels or high alloyed steels (in this case, carry out a cushion layer with **Selectarc HB MnCr** electrodes).

CLASSIFICATION EN 14700 : E Fe15**TOTAL ALLOY CONTENT:** 41 % (Carbon, Manganese, Chromium, Iron)**TYPICAL APPLICATIONS**

Principally destined to agriculture, cement industries, quarries, brickyards, civil engineering, for screws of brick press, excavating jars, ...

PROCEDURE

Maintain an arc length of 2 to 5 mm, weave with the electrodes. Hold the electrode perpendicularly to the surface. Do not apply more than 2 layers.

MECHANICAL PROPERTIES

Hardness (1st layer): 55 - 60 HRC
 Hardness (2nd layer): 58 - 62 HRC
 Deposit thickness: 2 passes maximum

WELDING PARAMETERS

Diameter:	12.0 mm (1/2")	8.0 mm (3/8")	6.0 mm (1/4")
Amperage:	210 - 250 A	120 - 180 A	80 - 120 A

WELDING POSITIONS

1G/PA

Rev.: 7_01

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