



Selectarc HB61B

Hardfacing Electrode resistant to Impact, compression and abrasion

Classification

DIN 8555 : E6-UM-60-S

EN 14700 : E Fe8

Description & Applications

Basic coated general purpose hardfacing electrode for applications subject to impact, compression and abrasive wear. For hardfacing on components made of C-steel, cast steel and Manganese steel. The deposit is tough-hard and crack resistant. Recovery of the electrode approx. 120%.

General applications: Hardfacing of block presses, crusher jaws, wheel rims, rollers, caterpillar tracks, ploughshares, running surfaces, cutting edges, ...

Typical Weld Metal Composition (%)

C	Si	Mn	Cr	Fe
0.5	2.0	0.6	9.5	Rem.

All Weld Metal Mechanical Properties

Hardness

~58 HRC

Obtained in pour weld metal

Welding Current & Instructions

Electrode	ØxL (mm)	2,5x350	3,2x350	4,0x450	5,0x450
Current	(A)	60-90	90-120	110-160	170-210

Redrying 2h at 300°C, if necessary. Guide electrode almost vertically with a short arc. On materials sensitive to cracks a buffer-layer with selectarc 18/8Mn is recommended. 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.



1G/PA



2F/PB



2G/PC



3G/PF



4G/PE

= +

~ 70V

ind.12

