


HB 50 AC/DC±

HARDFACING

DESCRIPTION

Very versatile coated hardfacing electrode that produces a chromium carbides deposit with an excellent combined resistance against abrasion and impact strength. Carbides are dispersed throughout a tough alloy matrix that is wear, corrosion and heat resistant up to 900°F (480°C). Deposits have a low coefficient of friction. Easy flow, self-removing slag. Surfacing in 1 - 2 or eventually 3 layers. Cannot be flame cut. High recovery with minimum dilution.

TOTAL ALLOY CONTENT: 36 % (Carbon, Silicon, Manganese, Chromium, Iron)

TYPICAL APPLICATIONS

Use carbon and alloys steels, manganese steels and cast iron. Buckets, blades, buckets arms, chain links, mill hammers, pulleys, etc.

PROCEDURE

Redrying, if necessary, 1h/250°C. Weld with a short arc. For hardfacing where more than 3 passes are necessary, apply a cushion layer with an electrode type **Selectarc HB 14Mn** or **Selectarc HB MnCr**. Low alloyed, high carbon tool steels etc. have to be preheated to 250 - 400°C, depending on their composition and thickness. Slow cooling in still air after surfacing.

MECHANICAL PROPERTIES

Hardness (as-welded): 47 - 52 HRC
Deposit thickness: 2 - 3 passes maximum

WELDING PARAMETERS

Diameter:	5.0 mm (3/16")	4.0 mm (5/32")	3.2 mm (1/8")
Amperage:	175 - 220 A	125 - 175 A	100 - 130 A

WELDING POSITIONS



1G/PA



2G/PC

Flux-cored wire also available: **Selectarc FC 50**

Rev.: 21_08

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

FSH WELDING Canada

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