Selectarc

MMA Electrodes

Range & Ordering Guide

Coated electrodes for fabrication, specialist joining, casting repair and hardfacing.



Find Your Material or Application

Mild Steel · Rutile	02	Nickel Alloys	07
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Fabrication or Repair?

Choose the electrode by the job. For fabrication, start with joint position and steel grade. For a worn part, start with the wear mechanism and whether the rebuilt surface needs machining.

Request a Quote

Quote the grade reference, size and quantity. Include the classification or approval required by your procedure.

Manufacturer technical literature

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GRADE REFERENCES & TECHNICAL DATA

Electrode Selection

Mild Steel · Rutile / Mild Steel · Low Hydrogen / Low-Alloy & Pressure Steels

160
MILD STEEL · RUTILE TDS

E7024

High-deposition rutile grade for long downhand butt welds and production fillets.

Ø × length (mm) 3.2 × 450, 4.0 × 450, 5.0 × 450

48SP
MILD STEEL · RUTILE TDS

E6013

Easy-striking mild-steel electrode for changing positions, including vertical down.

Ø × length (mm) 2.0 × 300, 2.5 × 350, 3.2 × 350, 3.2 × 450, 4.0 × 350, 4.0 × 450

51
MILD STEEL · RUTILE TDS

E6013

General mild-steel fabrication where easy slag removal and low open-circuit voltage operation matter.

Ø × length (mm) 1.6 × 300, 2.0 × 300, 2.5 × 350, 3.2 × 350, 3.2 × 450, 4.0 × 350, 4.0 × 450, 5.0 × 450

54
MILD STEEL · RUTILE TDS

E6013

Smooth-running rutile grade for workshop fillets, downhand work and vertical-up joints.

Ø × length (mm) 2.0 × 300, 2.5 × 350, 3.2 × 350, 3.2 × 450, 4.0 × 350, 4.0 × 450, 5.0 × 450

55
MILD STEEL · RUTILE

E6013

Heavy-coated rutile option for flat seams, concave fillets and finishing passes.

D6
MILD STEEL · RUTILE

E6013

Rutile-cellulosic option for fabrication with frequent vertical-down joints.

B56S
MILD STEEL · LOW HYDROGEN TDS

E7018-1

Low-hydrogen basic grade for heavily loaded fabrication with low-temperature toughness requirements.

Ø × length (mm) 2.5 × 350, 3.2 × 350, 3.2 × 450, 4.0 × 450, 5.0 × 450

B58
MILD STEEL · LOW HYDROGEN

E7018

Iron-powder low-hydrogen electrode for stressed structural joints and clean slag removal.

B7016SP
MILD STEEL · LOW HYDROGEN TDS

E7016

Double-coated basic electrode for structural root passes and positional repairs.

Ø × length (mm) 2.5 × 350, 3.2 × 350, 3.2 × 450, 4.0 × 450, 5.0 × 450

B7018S
MILD STEEL · LOW HYDROGEN TDS

E7018-1

Low-hydrogen basic grade for load-bearing fabrications such as frames and supports.

Ø × length (mm) 2.5 × 350, 3.2 × 350, 3.2 × 450, 4.0 × 450, 5.0 × 450

B70
LOW-ALLOY & PRESSURE STEELS

E10018-G

Fine-grained high-strength steel joints and specified buffer layers before hardfacing.

B72
LOW-ALLOY & PRESSURE STEELS TDS

E9018-G

Tough low-hydrogen deposit for root runs on suitable fine-grained steels.

Ø × length (mm) 2.5 × 350, 3.2 × 350, 4.0 × 450, 5.0 × 450

B73
LOW-ALLOY & PRESSURE STEELS

E9018-D1

High-yield low-hydrogen option for fine-grained steels in specified service.

Quote the electrode reference, diameter, length and quantity. Ask for pack options.

Manufacturer literature

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GRADE REFERENCES & TECHNICAL DATA

Low-Alloy & Pressure Steels

Select by parent steel, strength, toughness and service temperature. The range covers fine-grained, weathering and creep-resistant steels.

B74
LOW-ALLOY & PRESSURE STEELS

E8018-G

Fine-grained and heat-treated C-Mn steels where increased yield strength is required.

B75CU
LOW-ALLOY & PRESSURE STEELS TDS

E8018-W2

Cu-Ni-Cr deposit for compatible weathering steels exposed to the atmosphere.

Ø × length (mm) 2.5 × 350, 3.2 × 350, 4.0 × 450, 5.0 × 450

B77
LOW-ALLOY & PRESSURE STEELS

E11018-M

High-strength Ni-Cr-Mo-Mn deposit for matching fine-grained steels.

B60
LOW-ALLOY & PRESSURE STEELS TDS

E7018-A1

Molybdenum-bearing deposit for matching creep-resistant steels in process plant.

Ø × length (mm) 2.5 × 350, 3.2 × 350, 4.0 × 450, 5.0 × 450

B63
LOW-ALLOY & PRESSURE STEELS TDS

E8018-B2

1Cr-0.5Mo grade for compatible boiler and steam pipe steels.

Ø × length (mm) 2.5 × 350, 3.2 × 350, 4.0 × 450, 5.0 × 450

B68
LOW-ALLOY & PRESSURE STEELS TDS

E9018-B3

Cr-Mo electrode for compatible creep-resistant steels and specified castings.

Ø × length (mm) 2.5 × 350, 3.2 × 350, 4.0 × 450, 5.0 × 450

B69
LOW-ALLOY & PRESSURE STEELS TDS

E8018-B6

Cr-Mo electrode for matching steels exposed to hot gas or steam.

Ø × length (mm) 2.5 × 350, 3.2 × 350, 4.0 × 450, 5.0 × 450

B609
LOW-ALLOY & PRESSURE STEELS

E8016-B8

Low-hydrogen Cr-Mo grade for compatible high-temperature steels.

B691
LOW-ALLOY & PRESSURE STEELS

E9015-B9

Basic grade for specified P91 creep-resistant steel welding.

B81
LOW-ALLOY & PRESSURE STEELS TDS

E8018-C3

Nickel-bearing electrode for strong, tough joints in low-temperature steels.

Ø × length (mm) 2.5 × 350, 3.2 × 350, 4.0 × 450, 5.0 × 450

B82
LOW-ALLOY & PRESSURE STEELS TDS

E8018-C1

Nickel-bearing electrode for cold-tough fine-grained steels.

Ø × length (mm) 2.5 × 350, 3.2 × 350, 4.0 × 450, 5.0 × 450

B84
LOW-ALLOY & PRESSURE STEELS TDS

E8018-C2

Higher-nickel electrode for specified fine-grained steels used at low temperatures.

Ø × length (mm) 2.5 × 350, 3.2 × 350, 4.0 × 450, 5.0 × 450

Quote the electrode reference, diameter, length and quantity. Ask for pack options.

Manufacturer literature

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GRADE REFERENCES & TECHNICAL DATA

Electrode Selection

Low-Alloy & Pressure Steels / Stainless & High-Alloy Steels

B842
LOW-ALLOY & PRESSURE STEELS TDS

E7018-G

Nickel-bearing low-hydrogen option for low-temperature strength and toughness.

Ø × length (mm) 2.5 × 350, 3.2 × 350, 4.0 × 450, 5.0 × 450

20-10-BC
STAINLESS & HIGH-ALLOY STEELS TDS

E308L-16

Low-carbon stainless rutile-basic electrode with a low-moisture-pickup coating.

Ø × length (mm) 2.0 × 300, 2.5 × 300, 3.2 × 350, 4.0 × 350, 5.0 × 450

Inox-308B
STAINLESS & HIGH-ALLOY STEELS

E308L-15

Basic-coated low-carbon austenitic grade for matching 308L-type work.

Inox-308HR
STAINLESS & HIGH-ALLOY STEELS

High-recovery 19Cr-9Ni grade for productive stainless welds.

Inox-308HB
STAINLESS & HIGH-ALLOY STEELS

E308H-15

Basic-coated higher-carbon stainless grade for specified 308H applications.

Inox-347
STAINLESS & HIGH-ALLOY STEELS TDS

E347-17

Niobium-stabilised deposit for compatible titanium- or niobium-stabilised stainless.

Ø × length (mm) 2.0 × 300, 2.5 × 300, 3.2 × 350, 4.0 × 350, 5.0 × 450

Inox-16-8-2B
STAINLESS & HIGH-ALLOY STEELS TDS

E16

Basic 16-8-2 stainless electrode for specified higher-temperature applications.

Ø × length (mm) 2.5 × 300, 3.2 × 350, 4.0 × 350

20-10-MBC
STAINLESS & HIGH-ALLOY STEELS TDS

E316L-16

Low-carbon molybdenum-bearing stainless deposit with a low-moisture-pickup coating.

Ø × length (mm) 1.6 × 250, 2.0 × 300, 2.5 × 300, 3.2 × 350, 4.0 × 350, 5.0 × 450

INOX316L
STAINLESS & HIGH-ALLOY STEELS TDS

E316L-17

Low-carbon molybdenum-bearing stainless electrode for matching 316L service.

Ø × length (mm) 2.0 × 300, 2.5 × 350, 3.2 × 350, 4.0 × 450

316VD
STAINLESS & HIGH-ALLOY STEELS

E316L-16

Molybdenum-bearing stainless electrode designed for vertical-down welding.

INOX-316NG
STAINLESS & HIGH-ALLOY STEELS

E316L-15

Basic-coated low-carbon stainless grade with molybdenum for specified high-integrity welds.

Inox-318
STAINLESS & HIGH-ALLOY STEELS TDS

E318-17

Niobium-stabilised Mo-bearing stainless deposit for matching stabilised grades.

Ø × length (mm) 2.0 × 300, 2.5 × 300, 3.2 × 350, 4.0 × 350, 5.0 × 450

Inox-317L
STAINLESS & HIGH-ALLOY STEELS TDS

ISO 3581-A : E Z 19 13 4 L R 3 2

Low-carbon Mo-rich stainless deposit for compatible 317L work.

Ø × length (mm) 2.0 × 300, 2.5 × 300, 3.2 × 350, 4.0 × 350

24-12S
STAINLESS & HIGH-ALLOY STEELS

E309L-16

For specified stainless-to-low-alloy joints and stainless buffer layers.

Quote the electrode reference, diameter, length and quantity. Ask for pack options.

Manufacturer literature

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GRADE REFERENCES & TECHNICAL DATA

Stainless & High-Alloy Steels

Select a matching stainless grade or a dissimilar grade where dilution requires it. Match the coating and position to the procedure.

309HR
STAINLESS & HIGH-ALLOY STEELS

E309L-26

High-recovery 24Cr-13Ni deposit for productive dissimilar and overlay work.

24-12-Mo
STAINLESS & HIGH-ALLOY STEELS TDS

E309MOL-17

Molybdenum-bearing dissimilar electrode for specified joints involving 316L or mild steel.

Ø × length (mm) 2.0 × 300, 2.5 × 300, 3.2 × 350, 4.0 × 350, 5.0 × 450

307R
STAINLESS & HIGH-ALLOY STEELS TDS

E307-16 (approx.)

Rutile austenitic grade for manganese steel, dissimilar joints and buffer deposits.

Ø × length (mm) 2.5 × 300, 3.2 × 350, 4.0 × 350, 5.0 × 350

307B
STAINLESS & HIGH-ALLOY STEELS TDS

E307-15 (approx.)

Basic austenitic grade for specified manganese steel joining and overlay.

Ø × length (mm) 2.5 × 300, 3.2 × 350, 4.0 × 350, 5.0 × 450

18-8Mn
STAINLESS & HIGH-ALLOY STEELS TDS

E307-26 (approx.)

High-recovery manganese-bearing stainless electrode for overlays and dissimilar joining.

Ø × length (mm) 2.5 × 350, 3.2 × 350, 4.0 × 450

Inox-308Mo
STAINLESS & HIGH-ALLOY STEELS TDS

E308MO-17 (approx.)

Mo-bearing austenitic-ferritic stainless deposit for specified dissimilar joints.

Ø × length (mm) 2.5 × 300, 3.2 × 350, 4.0 × 350

29-9
STAINLESS & HIGH-ALLOY STEELS TDS

E312-16 (approx.)

High-alloy maintenance electrode for difficult-to-weld steels and dissimilar joints.

Ø × length (mm) 1.6 × 250, 2.0 × 300, 2.5 × 300, 3.2 × 350, 4.0 × 350, 5.0 × 450

Inox-312HR
STAINLESS & HIGH-ALLOY STEELS TDS

E312-26 (approx.)

High-recovery repair grade for overlay and joining compatible high-strength steels.

Ø × length (mm) 2.0 × 300, 2.5 × 350, 3.2 × 350, 4.0 × 450

25-20R
STAINLESS & HIGH-ALLOY STEELS TDS

E310-16 (approx.)

Rutile-basic 25Cr-20Ni deposit for heat- and oxidation-resistant stainless work.

Ø × length (mm) 2.0 × 300, 2.5 × 300, 3.2 × 350, 4.0 × 350, 5.0 × 450

25-20B
STAINLESS & HIGH-ALLOY STEELS

E310-15

Basic 25Cr-20Ni grade for specified heat-resistant stainless joints.

Inox-310H
STAINLESS & HIGH-ALLOY STEELS

E310H-15

Higher-carbon heat-resistant grade for compatible alloys and cast furnace tubes.

Inox253-MA-AC
STAINLESS & HIGH-ALLOY STEELS TDS

ISO 3581-A : E 22 12 R 3 2 EN 1600 E 22 12 R 3 : 2

Rutile electrode for compatible 253 MA-type heat-resistant stainless.

Ø × length (mm) 2.5 × 300, 3.2 × 350, 4.0 × 350

Quote the electrode reference, diameter, length and quantity. Ask for pack options.

Manufacturer literature

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GRADE REFERENCES & TECHNICAL DATA

Electrode Selection

Stainless & High-Alloy Steels / Cast Iron Repair

Inox-21-33MN
STAINLESS & HIGH-ALLOY STEELS TDS

ISO 3581-A : E Z 21 33 Mn Nb B 42

Basic high-nickel grade for compatible heat-resistant alloys and castings.

Ø × length (mm) 2.5 × 300, 3.2 × 350, 4.0 × 350

25/35H
STAINLESS & HIGH-ALLOY STEELS

High-carbon 25Cr-35Ni-type deposit for specified high-temperature cast equipment.

Inox-2209
STAINLESS & HIGH-ALLOY STEELS TDS

E2209-17

Rutile-basic duplex grade for compatible corrosion-resistant stainless joints.

Ø × length (mm) 2.5 × 300, 3.2 × 350, 4.0 × 350

Inox-2209B
STAINLESS & HIGH-ALLOY STEELS TDS

E2209-15

Basic duplex option for specified applications subject to pitting and crevice corrosion.

Ø × length (mm) 2.5 × 300, 3.2 × 350, 4.0 × 350

Inox-2509Mob
STAINLESS & HIGH-ALLOY STEELS TDS

E2594-15

Molybdenum-bearing basic electrode for compatible super duplex joints.

Ø × length (mm) 2.5 × 300, 3.2 × 350, 4.0 × 350

Inox-2509MoWB
STAINLESS & HIGH-ALLOY STEELS TDS

E2595-15

Tungsten-bearing basic electrode for specified super duplex service.

Ø × length (mm) 2.5 × 300, 3.2 × 350, 4.0 × 350

Inox-385
STAINLESS & HIGH-ALLOY STEELS TDS

E385-16

Fully austenitic, corrosion-resistant deposit for compatible 904L-type steels.

Ø × length (mm) 2.5 × 300, 3.2 × 350, 4.0 × 350

Inox-383
STAINLESS & HIGH-ALLOY STEELS TDS

E383-16

Fully austenitic deposit for Sanicro 28 and comparable corrosion-resistant alloys.

Ø × length (mm) 2.5 × 300, 3.2 × 350, 4.0 × 350

Inox-410B
STAINLESS & HIGH-ALLOY STEELS TDS

E410-15

Basic grade for repair and surfacing of compatible ferritic chromium steels.

Ø × length (mm) 2.5 × 350, 3.2 × 350, 4.0 × 450, 5.0 × 450

Inox-13-4
STAINLESS & HIGH-ALLOY STEELS TDS

E410NIMO-15

Martensitic Cr-Ni filler for compatible castings, pumps and hydraulic turbines.

Ø × length (mm) 2.5 × 350, 3.2 × 350, 4.0 × 450

Inox-17-4Mo
STAINLESS & HIGH-ALLOY STEELS

Basic Cr-Ni-Mo stainless grade for compatible martensitic castings and repairs.

Fonte-Ni
CAST IRON REPAIR

Pure nickel repair electrode for cold welding and crack repair on grey cast iron.

Quote the electrode reference, diameter, length and quantity. Ask for pack options.

Manufacturer literature

R H Davey Welding Supplies Ltd · 023 8033 9443 · sales@rhdaveywelding.co.uk
67–69 Quayside Road, Southampton SO18 1AE

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GRADE REFERENCES & TECHNICAL DATA

Electrode Selection

Cast Iron Repair / Nickel Alloys

Fonte-Ni2
CAST IRON REPAIR TDS

ENI-CI

Pure nickel cold-repair electrode for grey iron on DC electrode negative or AC.

Ø × length (mm) 2.5 × 350, 3.2 × 350, 4.0 × 350

Fonte-Ni4
CAST IRON REPAIR

Pure nickel grey-iron repair grade with a barium-free non-conductive coating.

Ferro-Ni
CAST IRON REPAIR TDS

ENIFE-CI

Nickel-iron electrode for joining and repairing nodular iron castings.

Ø × length (mm) 2.5 × 350, 3.2 × 350, 4.0 × 350, 5.0 × 350

BiMetal-NiFe
CAST IRON REPAIR TDS

ENIFE-CI

High-conductivity bimetal core for productive nickel-iron casting repairs.

Ø × length (mm) 2.5 × 350, 3.2 × 350, 4.0 × 350

Fonte-BMP
CAST IRON REPAIR

Barium-free bimetal electrode for cold repair of compatible iron castings.

Fonte-NiCu
CAST IRON REPAIR

Nickel-copper repair electrode for grey or malleable iron where colour match matters.

Fonte-Fe
CAST IRON REPAIR TDS

EST

Iron-base repair electrode for old, difficult castings such as housings and pumps.

Ø × length (mm) 2.5 × 350, 3.2 × 350, 4.0 × 450

Fonte-Fe3
CAST IRON REPAIR TDS

ISO 1071 : E C FeC-GF 3

For hot welding compatible nodular iron when a matching deposit is required.

Ø × length (mm) 3.2 × 350, 4.0 × 450, 5.0 × 450, 6.0 × 450

B90
NICKEL ALLOYS TDS

ENICRFE-3

High-recovery nickel-chromium electrode for specified nickel alloy and 5% nickel steel work.

Ø × length (mm) 2.5 × 350, 3.2 × 350, 4.0 × 350, 5.0 × 450

B91
NICKEL ALLOYS TDS

ENICRMO-3

High-recovery Ni-Cr-Mo electrode for joining and overlay on compatible alloys.

Ø × length (mm) 2.5 × 350, 3.2 × 350, 4.0 × 350

B94
NICKEL ALLOYS

High-recovery Ni-Cr-Fe electrode for compatible nickel alloys and cryogenic nickel steels.

B96
NICKEL ALLOYS

High-recovery basic electrode designed for AC operation to limit magnetic arc blow.

Ni59
NICKEL ALLOYS TDS

ENICRMO-13

Corrosion-resistant Ni-Cr-Mo electrode for matching Alloy 59 and specified dissimilar joints.

Ø × length (mm) 2.5 × 350, 3.2 × 350, 4.0 × 350

Quote the electrode reference, diameter, length and quantity. Ask for pack options.

Manufacturer literature

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GRADE REFERENCES & TECHNICAL DATA

Electrode Selection

Nickel Alloys / Aluminium / Copper Alloys

Ni82
NICKEL ALLOYS **TDS**

ENICRFE-3 (approx.)

Ni-Cr electrode for compatible nickel and ferrous alloys, cladding and dissimilar joints.

Ø × length (mm) 2.5 × 300, 3.2 × 350, 4.0 × 350, 5.0 × 450

Ni182
NICKEL ALLOYS **TDS**

ENICRFE-3

Ni-Cr-Fe electrode for compatible nickel alloys and cryogenic nickel steels.

Ø × length (mm) 2.5 × 300, 3.2 × 350, 4.0 × 350, 5.0 × 450

Ni190
NICKEL ALLOYS **TDS**

ENICU-7

Nickel-copper electrode for compatible Ni-Cu joining and surfacing.

Ø × length (mm) 2.5 × 300, 3.2 × 350, 4.0 × 350

Ni276
NICKEL ALLOYS

Ni-Cr-Mo electrode for Alloy C-276 and specified corrosion-resistant joints.

Ni625
NICKEL ALLOYS

Basic Ni-Cr-Mo electrode for compatible Alloy 625, dissimilar joints and overlays.

Ni625BF
NICKEL ALLOYS

Basic Ni-Cr-Mo option for specified joining and cladding on compatible alloys.

Ni-A
NICKEL ALLOYS

Basic nickel-alloy electrode for specified heat-resistant and dissimilar joints.

NiTi-3
NICKEL ALLOYS **TDS**

ENI-1

Titanium-bearing nickel electrode for pure nickel joining and selected overlays.

Ø × length (mm) 2.5 × 350, 3.2 × 350, 4.0 × 350

Al105
ALUMINIUM

5% silicon aluminium electrode for welding or repairing compatible aluminium alloys.

Al112
ALUMINIUM

12% silicon aluminium electrode for compatible cast or extruded aluminium alloys.

CU110
COPPER ALLOYS **TDS**

Copper-base electrode for compatible pure copper joining, surfacing and repairs.

Ø × length (mm) 2.5 × 350, 3.2 × 350, 4.0 × 350

CU114
COPPER ALLOYS **TDS**

Tin-bronze welding electrode for compatible Cu-Sn alloys and specified dissimilar joints.

Ø × length (mm) 2.5 × 350, 3.2 × 350, 4.0 × 350

CU115
COPPER ALLOYS **TDS**

Tin-bronze electrode for compatible Cu-Sn alloys and specified brass or dissimilar joints.

Ø × length (mm) 2.5 × 350, 3.2 × 350, 4.0 × 350

CU116
COPPER ALLOYS

Aluminium-bronze electrode for joining and overlay, including specified steel-to-bronze work.

Quote the electrode reference, diameter, length and quantity. Ask for pack options.

Manufacturer literature

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GRADE REFERENCES & TECHNICAL DATA

Electrode Selection

Copper Alloys / Hardfacing & Build-Up

CU118
COPPER ALLOYS TDS

Manganese-bronze deposit for aluminium-bronze surfacing and specified dissimilar joints.

Ø × length (mm) 2.5 × 350, 3.2 × 350, 4.0 × 350

CuNi30
COPPER ALLOYS TDS

Copper-nickel electrode for compatible 70/30 alloys and final layers on clad steels.

Ø × length (mm) 2.5 × 300, 3.2 × 350, 4.0 × 350

HB25
HARDFACING & BUILD-UP TDS

Rutile build-up for moderate friction, compression and cavitation.

Ø × length (mm) 2.5 × 350, 3.2 × 450, 4.0 × 450, 5.0 × 450

HB300B
HARDFACING & BUILD-UP TDS

Machinable basic build-up for equipment parts under moderate friction and compression.

Ø × length (mm) 3.2 × 350, 4.0 × 450, 5.0 × 450

HB40
HARDFACING & BUILD-UP

For pressure and wear on compatible low-alloy and cast-steel machine parts.

HB60
HARDFACING & BUILD-UP TDS

For medium abrasion and shocks on compatible low-alloy and cast-steel parts.

Ø × length (mm) 2.5 × 350, 3.2 × 450, 4.0 × 450, 5.0 × 450

HB40HT
HARDFACING & BUILD-UP TDS

Tough, heat-resistant build-up for hot-service tooling and machine parts.

Ø × length (mm) 2.5 × 300, 3.2 × 350, 4.0 × 450

HB48HT
HARDFACING & BUILD-UP

Hot-service overlay where both toughness and elevated-temperature performance matter.

HB56HT
HARDFACING & BUILD-UP

Hard, tough hot-service overlay for tooling and machinery components.

HB450HT
HARDFACING & BUILD-UP TDS

Carbide-bearing martensitic overlay for metal-to-metal wear.

Ø × length (mm) 2.5 × 350, 3.2 × 350, 4.0 × 450

HB600HT
HARDFACING & BUILD-UP

Cr-Mo-C overlay for hot or cold metal-to-metal wear.

HB50Co
HARDFACING & BUILD-UP

Overlay for metal-to-metal wear with heat and corrosion exposure.

HBMar50
HARDFACING & BUILD-UP

Age-hardenable deposit for metal-to-metal wear at elevated temperatures.

Quote the electrode reference, diameter, length and quantity. Ask for pack options.

Manufacturer literature

R H Davey Welding Supplies Ltd · 023 8033 9443 · sales@rhdaveywelding.co.uk
67–69 Quayside Road, Southampton SO18 1AE

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GRADE REFERENCES & TECHNICAL DATA

Hardfacing & Build-Up

Identify the wear mechanism first. Abrasion, impact and metal-to-metal wear call for different deposits and sometimes a buffer layer.

HBC62
HARDFACING & BUILD-UP TDS

Hard cutting-edge surfacing for compatible lathe and planer tooling.

Ø × length (mm) 2.5 × 350, 3.2 × 350, 4.0 × 450

HB61B
HARDFACING & BUILD-UP TDS

Basic-coated general hardfacing for combined abrasion, compression and impact.

Ø × length (mm) 2.5 × 350, 3.2 × 350, 4.0 × 450, 5.0 × 450

HB61R
HARDFACING & BUILD-UP TDS

Rutile-basic general hardfacing for combined abrasion, compression and impact.

Ø × length (mm) 2.5 × 350, 3.2 × 350, 4.0 × 450

HMn
HARDFACING & BUILD-UP TDS

Work-hardening overlay for high-impact duty and specified manganese steel repairs.

Ø × length (mm) 3.2 × 450, 4.0 × 450, 5.0 × 450

HMnCr
HARDFACING & BUILD-UP

High-deposition overlay for high impact or cavitation combined with corrosion.

HB14Mn
HARDFACING & BUILD-UP

Manganese hardfacing option for high impact and compatible Hadfield steel work.

HB-CAVIT
HARDFACING & BUILD-UP

Overlay for impact, erosion and cavitation, or a specified cushion layer.

HB63
HARDFACING & BUILD-UP TDS

High-deposition overlay for mineral abrasion combined with moderate impact.

Ø × length (mm) 2.5 × 350, 3.2 × 350, 4.0 × 450, 5.0 × 450

HBA
HARDFACING & BUILD-UP TDS

High-recovery chromium-carbide overlay for high abrasion.

Ø × length (mm) 3.2 × 350, 4.0 × 350, 5.0 × 450

HB64S
HARDFACING & BUILD-UP TDS

Carbide-rich hardfacing for abrasion combined with friction and corrosion.

Ø × length (mm) 3.2 × 350, 4.0 × 450, 5.0 × 450

HB65
HARDFACING & BUILD-UP

Carbide-rich overlay for abrasion and friction at elevated temperature.

HB66
HARDFACING & BUILD-UP TDS

Carbide-forming hardfacing for specified hot abrasion and friction applications.

Ø × length (mm) 3.2 × 350, 4.0 × 450, 5.0 × 450

HB68
HARDFACING & BUILD-UP TDS

Heavy-coated hardfacing for severe abrasion and moderate impact.

Ø × length (mm) 3.2 × 350, 4.0 × 350

Quote the electrode reference, diameter, length and quantity. Ask for pack options.

Manufacturer literature

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GRADE REFERENCES & TECHNICAL DATA

Electrode Selection

Hardfacing & Build-Up / Cutting, Gouging & Heating

HB68Nb
HARDFACING & BUILD-UP

High-recovery carbide-rich deposit for severe abrasive wear.

HBC63
HARDFACING & BUILD-UP **TDS**

High-recovery cutting-edge overlay for compatible lathe and planer tools.

Ø × length (mm) 2.5 × 350, 3.2 × 350, 4.0 × 450

B92
HARDFACING & BUILD-UP

Ni-Cr-Mo surfacing electrode for corrosive service.

B92Co
HARDFACING & BUILD-UP

Cobalt-bearing Ni-Cr-Mo hardfacing grade for specified surfacing work.

HB95CoB
HARDFACING & BUILD-UP

Cobalt-bearing deposit for high-temperature service with corrosion and thermal cycling.

HRT60
HARDFACING & BUILD-UP

Tubular chromium-carbide electrode for abrasion and mineral erosion.

HRT63
HARDFACING & BUILD-UP

Tubular chromium-niobium carbide electrode for severe abrasion.

CO1
HARDFACING & BUILD-UP

Cobalt-chromium-tungsten overlay for severe wear where a hard cobalt deposit is specified.

CO12
HARDFACING & BUILD-UP **TDS**

Cobalt-chromium-tungsten overlay for specified metal-to-metal wear.

Ø × length (mm) 3.2 × 350, 4.0 × 350, 5.0 × 450

CO12S
HARDFACING & BUILD-UP

Cobalt alloy type 21 deposit for metal-to-metal wear and high-temperature oxidation resistance.

CO25
HARDFACING & BUILD-UP

Cobalt alloy type 25 deposit for metal-to-metal wear in hot service.

HRT68
HARDFACING & BUILD-UP **TDS**

Tubular tungsten- and chromium-carbide overlay for severe abrasion with little impact.

CUT100
CUTTING, GOUGING & HEATING

Arc cutting, piercing and bevelling on compatible industrial metals.

DCS
CUTTING, GOUGING & HEATING

Chamfering, gouging and grooving on compatible industrial metals.

Quote the electrode reference, diameter, length and quantity. Ask for pack options.

Manufacturer literature

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Cutting, Gouging & Heating

Coated rods for metal removal or local heating. Follow the product instructions for the task and parent material.

GOUG

CUTTING, GOUGING & HEATING

Arc gouging, grooving and joint preparation on compatible industrial metals.

THERM-200

CUTTING, GOUGING & HEATING

Local heating on small and medium-sized components.

Specify the Job

For cutting or gouging Tell us the base metal, thickness and the weld or material to remove.

For hardfacing or repair Tell us the part, parent metal, wear pattern and whether the finished surface must be machined.



Selectarc 54 · General-purpose rutile electrode

Quote the electrode reference, diameter, length and quantity. Ask for pack options.

Manufacturer literature

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