

## SE63®

### Coated repair electrode pure nickel

The BMI SE63® coated electrode is a basic-coated hardfacing electrode with a very high efficiency (190%).

It is specifically designed to provide exceptional resistance to mineral abrasion, while also offering good impact resistance under moderate conditions.

### PROPERTIES & APPLICATIONS

Thanks to its **high carbon (C) and chromium (Cr) content**, the deposited metal, composed of **chromium carbides**, provides **exceptional abrasion resistance**. Wear resistance of parts hardfaced with **BMI SE63®** can be up to **50 times higher** than that of conventional electrodes with the same hardness.

Perfectly suitable for **multi-layer applications**, the **BMI SE63® electrode** ensures **homogeneous fusion, good metal spread without slag, and a very smooth bead**. The formation of cracks in the deposited metal is **normal and does not affect its performance in service**.

This electrode has been **specifically developed for wear-resistant hardfacing** of parts subjected to **low to moderate impact**, where **exceptional abrasion resistance** is required.

### MECHANICAL CHARACTERISTICS OF THE DEPOSITED METAL

Hardness 1st Layer	Hardness 2nd Layer
~ 58 HRc	~ 60-63 HRc

### WELDING PARAMETERS

Ø x L (mm)	3.2 x 350	4 x 350	5 x 450
Intensity (A)	140	200	250

**Electrode Baking:** 250°C for 1 hour if necessary.

For hardfacing on **highly alloyed steels**, such as **tool steels**, it is recommended to use a **buffer layer** with the **BMI SE312® electrode**.

Preheat the workpiece between **200 and 400°C**, depending on the hardening risk and thickness, then allow for **slow cooling**.

### PACKAGING

4.5 kg Boxes

#### Groupe BMI

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