Selectarc HBMnCr

Electrode highly Resistant to Cavitation

Description & Applications

Synthetic basic coated electrode with high efficiency (140%), intended to surface all pieces subject to high impact and cavitation combined with corrosion. Also used for dissimilar joints between Mn- and construction steels and as cushion layer before hardfacing in case of heavy reclaiming. The deposit is austenitic and is exceptionally resistant to impact and wear combined with impact. The high amount of Cr increases the resistance against corrosion, abrasion and cavitation.

General applications: Repairing of used pieces or preventive protection of new pieces used in railway applications (rails, switches, crossings, tongues) in quarries and mines (crusher jaws, excavator and grab teeth, mill hammers, rock crusher) for hydro power stations and other industries (pistons of hydraulic presses, turbines).

Base materials **Austenitic steels with high Mn:**

DIN 17145 and 17155 : X110Mn14
AFNOR : Z120M12

All Weld Metal Mechanical Properties

Hardness as welded	Hardness after work hardening
~ 260 HB Obtained in pour weld metal	400-500 HB

Welding Current & Instructions

Electrode	ØxL (mm)	2,5x350	3,2x350	4,0x450	5,0x450
Current	(A)	90	130	160	220

Redrying 1h at 300°C, if necessary. Weld with a minimum heat input (low current, short beads) in order to respect an interpass temperature of 250°C maximum. Do not preheat the piece to weld!

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