



SELECTARC HB65

Coated Electrode for
Protection against High Abrasion

Classification

DIN 8555 : E 10-UM-65-GR EN 14700 : E Fe 15

Characteristics

Electrodes with a high alloy content of elements which form carbides. Therefore especially used for hardfacing of parts subject to high abrasion, friction, heat and corrosion. The electrode is easy to weld, has a uniform drop transfer and only a negligible slag content. Recovery approx. 190%.

Applications

Ash plows, Coke Crusher segments, Screw conveyers, Valves, Exhaust Fans, Agitator Fingers, Mill Guides, Mixer Paddles, Rake Teeth in Furnaces, Tong Bits, Slag Ladles, Elevator Bucket-tips etc at operation temperature upto 450°C.

Typical Weld Metal Composition (%)

C	Si	Cr	Nb	Fe
5.00	1.50	24.00	7.00	base

All Weld Metal Mechanical Properties (Typical)

Hardness (HRC)

AW

64

Welding Current & Instructions

Electrode	Ø x L (mm)	2.5 x 350	3.2 x 350	4.0 x 450	5.0 x 450
Current	(Amp)	90 - 110	130 - 150	140 - 190	190 - 250

Maintain a short arc and hold the electrode almost vertical. Select lowest amperage possible to keep dilution low and weave only slightly.



1G/PA

= + ~ 50 V

Liability: This document is intended to assist the user in choosing the product. It is up to the user to verify that the chosen product is suitable for applications for which it is intended. The company FSH Welding Group reserves the right to alter specifications without prior notice of its products. The descriptions, illustrations and specifications are for reference only and cannot be held liable for FSH Welding Group. **Fumes:** Consult information on MSDS, available upon request.