



SELECTARC HB68

Coated Electrode for
Hardfacing against High Abrasion

Classification

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

Characteristics

Heavy coated electrode with a high alloy content of elements which form carbides. Therefore used for hardfacing of parts subject to high abrasion, moderate impact and temperature. The electrode is easy to weld, has a uniform drop transfer, only a negligible slag content and easy restriking. Recovery approx. 240%.

Applications

For use in Steel Mills, On Crushers, Conveyor Screws, Dredger Parts, Sieves.

Typical Weld Metal Composition (%)

C	Cr	Other	Fe
5.00	36.00	4.00	base

All Weld Metal Mechanical Properties (Typical)

Hardness 1 st layer (HRC)	Hot Hardness	
	400°C HRC	600°C HRC
AW	57	55

Welding Current & Instructions

Electrode	Ø x L (mm)	3.2 x 350	4.0 x 350
Current	(Amp)	130 - 150	160 - 190

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.