



## SELECTARC HBA

### Hardfacing Electrode

### High Cr-Carbides

#### Classification

DIN 8555 : E 10-UM-60-GRZ EN 14700 : E Fe 15

#### Characteristics

Basic coated, slag free, hardfacing electrode with high recovery (190%). Highly resistant to abrasion due to its high content of Cr and C. The service life of surfaced pieces is up to 50 times longer than for conventional electrodes of similar hardness. Austenitic matrix containing Cr carbides. Deposit 1 or 2 layers maximum. Resists to heavy mineral abrasion and moderate shock. Only machinable by grinding. Regular drop transfer, no slag, smooth beads. The formation of cracks in the weld deposit is normal for this type of composition. For all pieces subject to low or moderate shock, resistance to abrasion is required.

#### Applications

For Endless screws, Mixer paddles, Pump bodies for abrasive materials, Excavator teeth, Crashing of mineral materials, Concrete pumps, Screws for Brick presses, Wear plates.

#### Typical Weld Metal Composition (%)

C	Si	Mn	Cr	Fe
5.00	1.00	0.50	35.00	base

#### All Weld Metal Mechanical Properties (Typical)

Hardness 2<sup>nd</sup> layer (HRC)

AW

60 - 63

#### Welding Current & Instructions

Electrode	∅ x L (mm)	3.2 x 350	4.0 x 350	5.0 x 450
Current	(Amp)	130 - 140	180 - 200	210 - 250

Redrying of electrode at 250°C for 1hr before use, if necessary. Guide electrode almost vertically with a short arc. In case of hardfacing high alloyed steels like tool steels, it is recommended to apply a cushion layer with selectarc 29/9 or 18/8Mn and to preheat the pieces to surface at 200 – 400°C, depending on the material and thickness, followed by slow cooling.



1G/PA

= + ~ 50 V

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