



# SELECTARC HB Mn Cr

## Electrode for Highly Resistant to Cavitation

### Classification

DIN 8555 : E7-UM-250-KPR      AWS A 5.13 : E FeMnCr  
 EN 14700 : E Fe9

### Characteristics

Basic coated synthetic electrode with high deposition efficiency (140%), intended to surface all components 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 it. The high amount of Cr increases the resistance against corrosion, abrasion and cavitation.

### Applications

Repairing of used pieces or 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	X 110 Mn 14
AFNOR	Z120M12

### Typical Weld Metal Composition (%)

C	Si	Mn	Cr	Fe
0.60	0.30	16.00	14.00	base

### All Weld Metal Mechanical Properties (Typical)

Hardness (HB) AW (Obtained on pure weld metal)	Hardness (after work hardening) HB
260	400 - 500

### Welding Current & Instructions

Electrode	ØxL (mm)	2.5 x 350	3.2 x 350	4.0 x 450	5.0 x 450
Current	(A)	80 - 90	120 - 130	150 - 160	210 - 220

Redrying of electrode at 300°C for 1hr before use. Weld with a minimum heat input (low current, short beads) in order to maintain an interpass temperature of 250°C maximum. Do not preheat the piece to weld.



1G/PA



2F/PB



2G/PC

= + ~ 65V

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