

selectarc HB66

**Coated Electrode for
Protection against high abrasion**



Classification

DIN 8555 : E10-UM-65-GRZ
EN 14700 : E Fe16

Description & Applications

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 smooth drop transfer and only a negligible slag content. Recovery approx. 200%.

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. Operation temperatures up to 550°C.

Typical Weld Metal Composition (%)

C	Si	Cr	Mo	Nb	W	V	Fe
5.0	1.5	22	7.0	7.0	2.0	1.0	base

All Weld Metal Mechanical Properties

Hardness
~ 65 HRC

Welding Current & Instructions

Electrode	ØxL (mm)	3,2x350	4,0x450	5,0x450
Current	(A)	110-140	140-190	190-250

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



1G/PA

= + ~ 50V



ind.05