

selectarc

HB68

**Coated Electrode for
Hardfacing against high abrasion**


FSH WELDING GROUP
INNOVATIVE WELDING CONSUMABLES
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Classification

DIN 8555 : E10-UM-65-GR

EN 14700 : E Fe15

Description & Applications

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

Main applications: For use in steel mills, on crushers, conveyor screws, dredger parts, sieve.

Typical Weld Metal Composition (%)

C	Cr	Others	Fe
5.0	36.0	4.0	Rem.

All Weld Metal Mechanical Properties

Hardness	Hot Hardness
~64 HRC on the 1 st layer	400°C: ~57 HRC ; 600°C: ~55 HRC

Welding Current & Instructions

Electrode	ØxL (mm)	3,2x350	4,0x350
Current	(A)	130-150	160-190

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.10

