Selectarc HB Cavit

Electrode highly Resistant to Cavitation

Description & Applications

Synthetic basic coated electrode with high efficiency (160%), destined to surface all pieces subject to high impact, erosion and cavitation. Also used as cushion layer before hardfacing in case of heavy reclaiming. The deposit is austenitic and is exceptionally resistant to impact and wear. The high amount of Cr highly increases the resistance to corrosion.

General applications: Repairing of used pieces or protection of new pieces in hydro power stations, pistons of hydraulic presses, different types of turbines, valves, ...)

Base materials **Austenitic steels with high Mn , martensitic stainless steels:**

DIN 17145 and 17155 : X110Mn14
X4CrNi 13 4 1.4313 ; G-X5CrNiMo 13 4 1.4407

All Weld Metal Mechanical Properties

Hardness as welded	Hardness after work hardening
200-250 HB Obtained in pour weld metal	400-500 HB

Welding Current & Instructions

Electrode	ØxL (mm)	3,2x350	4,0x450
Current	(A)	110-130	130-160

Redrying 1h at 300℃, if necessary. Guide electrode s with a slight declination, weld with a short arc and prevent a high heat input in order to respect an interpass temperature of 250℃ maximum. Do not preheat the piece to weld up to more than 100℃. He at treatment depends on the base metal.

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