



## Selectarc HB13MnB

*Electrode highly resistant to Impact*

### Description & Applications

Basic coated electrode, suitable to surface all pieces subject to high impact. Mainly used to repair defects in foundries 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 impact. Due to the special basic coating the weld pool is open and therefore this electrode is well adapted to weld in deep groves or holes.

**General applications:** Repairing of used pieces or preventive 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).

### Base materials

#### Austenitic steels with high Mn:

X120Mn12	1.3401
X110Mn14	1.3402
GX120Mn12	1.3403
AFNOR	Z120M12

### All Weld Metal Mechanical Properties

Hardness as welded

~ 230 HB

Obtained in pour weld metal

Hardness after work hardening

400-500 HB

### Welding Current & Instructions

Electrode	ØxL ( mm )	3,2x350	4,0x450	5,0x450
Current	( A )	130	160	200

Redrying 1h at 300°C, if necessary. Weld with a minimum heat input (low current, short beads) in order to respect an interpass temperature of 200°C maximum. Do not preheat the piece to weld! When surfacing other steels than 13%Mn types, apply a cushion layer with Selectarc 18/8Mn.

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