



## Selectarc HB14Mn

*Electrode highly Resistant to Impact*

### Description & Applications

Rutile-basic coated electrode, suitable to surface all pieces subject to high impact. Sometimes used, instead of selectarc 18/8Mn, for 13% Mn-steel assembling (Hadfield steels). Frequently used as cushion layer before hardfacing in case of heavy reclaiming. Allows to build up and then to apply abrasion resistant final layers, 1 or 2, using HBA or HB63. The deposit is austenitic and is exceptionally resistant to impact and wear combined with impact. The addition of Ni and Cr increases the resistance against cracks and abrasion.

**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:

DIN 17145 and 17155 : X110Mn14  
AFNOR : Z120M12

### All Weld Metal Mechanical Properties

Hardness as welded

200-250 HB

Obtained in pour weld metal

Hardness after work hardening

400-500 HB

### Welding Current & Instructions

Electrode	ØxL ( mm )	3,2x450	4,0x450	5,0x450
Current	( A )	120	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 250°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.

ind.13



= +,- ~ 65V

**Liability:** This document is intended to assist the user in choosing the product. It is up to the user to verify that the chosen product is suitable for applications for which it is intended. The company FSH Welding Group reserves the right to alter specifications without prior notice of its products. The descriptions, illustrations and specifications are for reference only and cannot be held liable for FSH Welding Group. **Fumes:** Consult information on MSDS, available upon request.

[www.fsh-welding.com](http://www.fsh-welding.com) - [info@fsh-welding.fr](mailto:info@fsh-welding.fr)