



Selectarc HB65

*Coated Electrode for
Protection against high abrasion*

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 at operation temperatures up to 450°C and corrosion. The electrode is easy to weld, has a smooth drop transfer and only a negligible slag content. Recovery approx. 190%.

General 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.

All Weld Metal Mechanical Properties

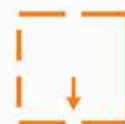
Hardness
~ 64HRC

Welding Current & Instructions

Electrode	ØxL (mm)	2,5x350	3,2x350	4,0x450	5,0x450
Current	(A)	90 - 110	130-150	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.

ind.13



= + ~ 50V

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