



Selectarc HB66

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 550°C and corrosion. The electrode is easy to weld, has a smooth drop transfer and only a negligible slag content. Recovery approx. 200%.

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.

All Weld Metal Mechanical Properties

Hardness
~ 65 HRC

Welding Current & Instructions

Electrode	ØxL (mm)	3,2x350	4,0x450	5,0x450
Current	(A)	110-140	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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