


**HB MnCr DC+**
**BUILD-UP**
**DESCRIPTION**

**High chromium synthetic basic coated build-up electrode** with high efficiency (140 %), destined to surface all pieces subject to high impact and cavitation. Also used for dissimilar joints between Mn and construction steels 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. The high amount of Chromium increases the resistance against corrosion, abrasion and cavitation.

**CLASSIFICATION**

AWS A5.13 : E FeMnCr

DIN 8555 : E7-UM-250-KPR

EN 14700 : E Fe9

**TOTAL ALLOY CONTENT:** 31 % (Carbon, Silicon, Manganese, Chromium)

**TYPICAL 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, rocks crusher ) for hydro power stations and other industries ( pistons of hydraulic presses, turbines).

**PROCEDURE**

Redrying, if necessary, 1h / 300°C (572°F). Weld with a minimum heat input (low current, short beads) in order to respect an interpass temperature of 260°C (500°F) maximum. Do not preheat the piece to weld!

**MECHANICAL PROPERTIES**

Tensile strength: 120 000 psi (827 MPa)

Hardness (as-welded): 20 - 25 HRC

Work hardening: 43 - 52 HRC

Deposit thickness: Unlimited

**WELDING PARAMETERS**

Diameter: 5.0 mm (3/16")

4.0 mm (5/32")

3.2 mm (1/8")

2.5 mm (3/32")

Amperage: 220 A

160 A

130 A

90 A

**WELDING POSITIONS**


1G/PA

2F/PB

2G/PC

Flux-cored wire also available: **Selectarc FC MnCr**

Rev.: 21\_08

*Specialized welding alloys and technology. For technical assistance or for ordering:*

**FSH WELDING** Canada

Membre de / Member of SELECTARC GROUP - FRANCE

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

2204, 46<sup>e</sup> avenue  
Lachine (Mtl), Québec  
Canada H8T 2P3

Tél : 514.631.7670

1.800.361.9097