



# Selectarc 18/8Mn

*High Mn Stainless Electrode  
For repairing and surfacing*

## Classification

AWS A5.4 : ~E307-26      EN 1600 : E 18 8 Mn R 7 3 X  
ISO 3581-A : E 18 8 Mn R 7 3 X

## Description & Applications

Rutile-basic electrode with high recovery (160%). Fully austenitic stainless steel deposit with a high Mn-content. For welding and cladding on Mn-steels (14% Mn), for dissimilar joints and difficult to weld materials, cushion layers prior hardfacing, repairing of pieces submitted to shocks. Easy to use, soft fusion, low spatters, slag easy to remove, regular weld beads, deposit highly resistant to cracks.

**Main applications:** For shops doing repairs on railways, earth moving, in quarries or on construction machinery, in cement works, on different types of crushers.

### Base materials

#### Screening steels

#### Tools steels\*

**Austenitic steels with Mn:** type Z 120 M 12, X 120 Mn 12, 1.3401

**Spring steels:** 45 Cr 4, 1.7035, 46 Si 7, 1.5024, 51 Si 7, 1.5025, 56 Si 7, 1.5026

(\* ) with eventual pre- and post weld heat treatment.

## Typical Weld Metal Composition ( % )

C	Si	Mn	Cr	Ni	Fe
0.1	0.8	5.0	18.0	8.5	Rem.

## All Weld Metal Mechanical Properties

$R_{p0.2}$ ( MPa )	$R_m$ ( MPa )	$A_5$ ( % )	KV ( J )
>400	600-750	>30	+20°C >70

Hardness: as welded ~ 200 HB, work hardened ~ 500 HB.

## Welding Current & Instructions

Electrode	ØxL ( mm )	2,5x350	3,2x350	4,0x450
Current	( A )	90	130	160

Redrying 2 hours at 250°C if necessary.

ind.12



= + ~ 50V

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