

E DUR 600

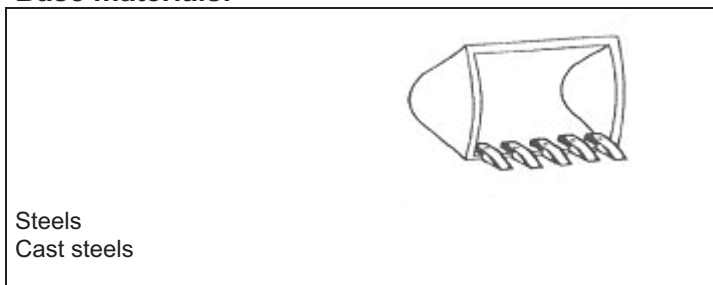
Description and application:

Electrode is used for surfacing of steel parts when heavy impact resistance is needed. Welding material possesses higher abrasion resistance.

Suitable for surfacing parts exposed to heavy abrasive wear by stone, coal, sand etc...

The weld metal can be treated with grinding and cut after soft annealing.

Base materials:



Heat treatment:

Coating type:
Basic

Welding current:

DC +

Welding positions:



Redrying temperature:
400°C / 1h

Typical weld metal properties:

Chemical composition, wt %:

C	Cr
0.5	8.5

Mechanical properties:

Hardness: 57-62 HRC (typical: 59 HRC)

The hardness of the deposit depending on the relevant welding conditions and the chemical composition of the base metal.

Welding and packing data:

Welding parameters			Packing		
φ mm	Length mm	Current A	Weight/ packet kg	Weight/ carton kg	Weight/ 1000 pcs kg *
2.5	300	70-90	4	20	18
3.25	350	100-135	4	20	36
4	450	140-180	5.4	27	68.4
5	450	180-230	5.4	27	108
6	450	240-280	5.4	27	154.3

* approximate data

Approvals:

sž