

Description

A general-purpose, hardfacing electrode depositing a corrosion-resistant fully martensitic steel. The electrode is suitable for hardfacing shafts, racks and pinions, links and pins, valve seats of cast steel, mixer arms, feed gear, knives, loading buckets and track rollers.

Generally, a preheat and interpass temperature of about 200°C is recommended for most applications.

Welding current

AC, DC+ OCV 70 V



Classifications

DIN 8555 E6-UM-55-GR

Typical all weld metal composition, %

C	Si	Mn	Cr
0.25	0.5	<0.5	13.0

Typical mech. properties all weld metal

Weld metal hardness, a w (deposited on mild steel, no preheat, interpass temperature 250°C)	49-55 HRC
1st layer	43- 49 HRC
2nd layer	46-52 HRC
3rd layer	49-55 HRC
Machinability	Grinding only
Abrasion resistance	Very good
High temp. wear resistance	Very good
Corrosion resistance	Very good

Tempering resistance

Temp°C/1h	HRC
100	52
200	50
300	50
400	52
500	55
600	47
700	35

Annealing and hardening of weld metal:

Soft annealing: 780-800°C
 Rehardening procedure:
 Hardening temperature, C: 950- 1000
 Quenching medium: compressed air or oil

Deposition data at max current

Diameter, mm	Length, mm	Welding current, A	Arc voltage, V	N. Kg weld metal/kg electrodes	B. No. of elec- trodes/kg weld metal	H. Kg weld metal/hour arc time	T. Burn-off time, s/ electrode
2.5	350	70-110	22	0.55	80.0	0.9	48
3.2	450	100-160	24	0.58	35.0	1.4	70
4.0	450	140-220	25	0.58	23.0	2.0	80
5.0	450	220-310	31	0.60	14.5	3.0	80