

Processing information

Re-drying: 100 - 150 °C/2 h
(if required)

Welding positions:



Polarity:



To avoid cracks preheating up to min.
500 °C, slow down cooling necessary.

Application

High-performance electrode for highly wear-resistant surfacings on machine parts which are exposed to strong grinding load. Through higher carbon and chromium content a high hardness and good wear-resistance can be achieved.

Field



Characteristic
rutile-coated,
190 % recovery

Standards
DIN EN 14700
E Fe15
DIN 8555
E 10-UM-65 GR

All Weld Metal Mechanical Properties

Weld Metal Composition [%]

C	Si	Mn	Cr
4,5	0,7	0,5	34

Hardness [HRC]

As-welded	62 - 64
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Welding Current, Packaging

Item no.	Dm./Länge [mm]	Amperage [A]	kg/Pack	= Piece/Pack	kg/1000 Pc.
00.618.253	2,50/350	90 - 120	5,0	152	32,9
00.618.323	3,25/350	120 - 160	5,0	90	55,6
00.618.404	4,00/450	150 - 190	6,0	55	109,1
00.618.504	5,00/450	180 - 240	6,0	35	171,4



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