

Dur MnCr

CATEGORY	SMAW Stick Electrodes		
TYPE	Basic hardfacing electrode with high impact and wear resistance		
APPLICATIONS	Basic electrode for rebuilding and joining cold straining Mn steels or rebuilding parts that are subject to high impact and rolling wear.		
PROPERTIES	There is no limit for the number of layers that can be applied in case of rebuilding but heat input should be kept low (as for Mn steel, interpass temperature should be kept <250°C).		
CLASSIFICATION	AWS	A 5.13: E FeMnCr	
	EN ISO	14700: E Fe9	
	DIN	8555: E 7-UM-250-K	
SUITABLE FOR	rebuilding and joining cold straining Mn steels or rebuilding parts that are subject to high impact and rolling wear. Breaker teeth, crushers, hammers, crossings, rails.		

APPROVALS CE approved

WELDING POSITIONS:



WELD METAL ANALYSIS %

C	Mn	Cr	Fe
0.5-0.6	16-18	13-15	bal

MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness HB
				-20°C	-40°C	-60°C	
AW							220-450

AW: as welded, 450 HB strain hardening

WELDING PARAMETERS / PACKING

Welding Parameters			Packing		
D (mm)	Length (mm)	Current (A) (DC+/AC)	kg / can	kg / 6 pack	kg / 1000
3.2	350	100-160	2.5	15	68
4.0	450	160-220	3.0	18	100
5.0	450	190-260	3.1	18.6	139

REDRYING TEMPERATURE 300C / 2hr