

Dur 63 Nb

CATEGORY	SMAW Stick Electrodes																																	
TYPE	Basic coated, high Chromium-Niobium based hardfacing alloy for SMAW																																	
APPLICATIONS	This electrode with a recovery of 190% can be used for overlays with extremely abrasive and sliding wear resistance, but with low impact. For use till 450°C.																																	
PROPERTIES	Very economical due to the high deposition rate and excellent weldability without slag losses. For critical base material or old hard facing layers it is necessary to buffer with an electrode like DUR E 350 Kb / E 11018-G that delivers a welding deposit of less hardness. Overlays on steel with high carbon content should be buffered with Croni 29/9 HL or 4370 HL. For the best results 2 till 3 layers should be welded.																																	
CLASSIFICATION	AWS	A 5.13: no standard																																
	EN ISO	14700: EZ Fe15																																
	DIN	8555: E 10-UM-65-GRZ																																
SUITABLE FOR	Sugar mill knives and hammers, cement mixers, clinker crushers, sintering lines, fire gratings, mixer blades, gravel washing equipment, ceramic mixer blades, extruders, crushing tables and rollers for lime stone etc.																																	
APPROVALS	CE approved																																	
WELDING POSITIONS:																																		
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REDRYING TEMPERATURE	300-320 °C/2h																																	
EQUIVALENT	FCAW - OA 59 - OA 64																																	