


## Dur 64

CATEGORY	SMAW Stick Electrodes				
TYPE	Basic coated, high Chromium-Niobium based hardfacing high recovery hardfacing electrode				
APPLICATIONS	This electrode with a recovery of 190% can be used for overlays with extremely abrasive and sliding wear resistance, but with middle impact.				
PROPERTIES	Due to the high Mo-content, abrasion resistance can be kept up to working temperatures of 600°C ; the hardness is still 40-45 HRC at these temperatures. For hardfacing of more than 3 layers it is necessary to buffer with an electrode like DUR E 350 Kb that delivers a welding deposit of less hardness. Overlays on steel with high tensile strength have to be buffered with Croni 29/9 HL or 4370 HL. Equivalent in FCAW: <a href="#">OA 64</a>				
CLASSIFICATION	AWS	A 5.13: E FeCr-E4			
	EN ISO	14700: E Fe16			
	DIN	8555: E 10-UM-65-Z			
SUITABLE FOR	Sugar mill knives and hammers, clinker crushers, sintering lines, fire gratings, mixer blades, gravel washing equipment, ceramic mixer blades, mill rollers, stone crushers, extruders etc....				
APPROVALS	CE approved				
WELDING POSITIONS:					
WELD METAL ANALYSIS %					
C	V	W	Cr	Nb	Mo
4.0-6.0	0.8-1.2	1.8-2.2	22.0-25.0	5.0-7.0	5.0-7.0
MECHANICAL PROPERTIES					
Heat Treatment	R <sub>p0,2</sub> (N/mm <sup>2</sup> )	R <sub>m</sub> (N/mm <sup>2</sup> )	A5 (%)	Hardness HRC	
				20°C	400°C
AW				63-66	40-45
AW: as welded					
WELDING PARAMETERS / PACKING					
Welding Parameters			Packing		
D (mm)	Length (mm)	Current (A)	kg / can	kg / 6 pack	kg / 1000
3.2	350	100-160	2.4	14.4	69.5
4.0	450	160-220	2.9	17.4	135.1
5.0	450	190-260			208.3
REDRYING TEMPERATURE	not required				