

Dur CE-Tube 62

CATEGORY SMAW Stick Electrodes

TYPE Tubular hardfacing electrode with C-Cr-Mo-B-V carbides.

APPLICATIONS This electrode with his extreme recovery offers excellent wear resistance in high velocity, fine particle applications in which erosive wear is a major problem. Further to be used against high general wear and medium impact.

PROPERTIES Due to the Mo-content, abrasion resistance can be kept also with increased temperatures. For hardfacing of more than 3 layers it is recommended 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 should be buffered with Croni 29/9 HL or 4370 HL.

- 1) up to 3 times faster ! (less current with more deposit)
- 2) No slag losses compare to 40% loss with standard electrodes.!
- 3) Low amperage offers much lower heat input ! (see point 1)
- 4) 6 mm is ideal to weld in position and on sharp edges !
- 5) Moisture resistant coating even in extreme humidity conditions !

CLASSIFICATION

AWS	A 5.13: ~E FeCr-A7
EN ISO	14700: E Fe14
DIN	8555: E 10-UM-60-Z

SUITABLE FOR Tubular hardfacing alloy for Sugar mill knives and hammers, clinker crushers, liner plates, ripper tines, mixer blades, gravel washing equipment, ceramic mixer blades, paddles, extruders.

WELDING POSITIONS:



WELD METAL ANALYSIS %

C	Cr	Mo	V	B	Nb
4.0	25.0	2.0	0.6	1.75	-

MECHANICAL PROPERTIES

Heat Treatment	Rp0,2 (N/mm ²)	Rm (N/mm ²)	A5 (%)	Impact Energy (J) ISO-V			Hardness HRc
				-20°C	-40°C	-60°C	
AW							58-63

AW: as welded

WELDING PARAMETERS / PACKING

D (mm)	Welding Parameters		kg / can	Packing	
	Length (mm)	Current (A)		kg / 6 pack	kg / 1000
6	450	80-130	3.5	21.0	82.64
8	450	140-190			151.52
12	450	<425			227.27