

Dur E 350 Kb

CATEGORY SMAW Stick Electrodes

TYPE Basic coated electrode for hardfacing machine parts, buffer layers and rebuilding rails and crossings..

APPLICATIONS Hardfacing and rebuilding machine parts that faces high impact and wear. The alloy is also excelent for buffer layers prior to hardfacing.

PROPERTIES Dur E 350 Kb is a hardfacing electrode against high impact combined with abrasion. This alloy has no risk for cracks and can also be applied on austenitic manganese steels. The weld deposit is good machinable. Very good weld deposit appearance and outstanding welding properties on both AC and DC+. Preheating is not required. Outstanding slag release.

CLASSIFICATION

| | |
|--------|--------------------|
| AWS | A 5.13: E Fe1 |
| EN ISO | 14700: E Fe1-400-p |
| DIN | 8555: E1-UM-400P |

SUITABLE FOR Rebuilding worn machine parts such as, rails, crossings, wheels, dredging parts, Stone crushers, Hammers, Gears, Cams, bearings, rope winches etc.

APPROVALS CE approved

WELDING POSITIONS:



WELD METAL ANALYSIS %

| | | | |
|-------|------|-----|---------|
| C | Mn | Fe | Cr |
| <0,15 | <1.0 | rem | 2.5-3.5 |

MECHANICAL PROPERTIES

| Heat Treatment | R _{p0,2} (N/mm ²) | R _m (N/mm ²) | A5 (%) | Hardness HB | | |
|----------------|---|--|-----------|-------------|-----------|-----------|
| | | | | 1st layer | 2nd layer | 3th layer |
| AW | | | | 325 | 350 | 370 |

AW: as welded, >350 HB without PWHT at RT

WELDING PARAMETERS / PACKING

| Welding Parameters | | | Packing | | |
|--------------------|-------------|--------------------|----------|-------------|-----------|
| D (mm) | Length (mm) | Current (A) DC+/AC | kg / can | kg / 6 pack | kg / 1000 |
| 3.2 | 350 | 100-140 | 2.8 | 16.8 | 36 |
| 4.0 | 450 | 140-180 | 3,2 | 19,2 | 66 |
| 5.0 | 450 | 180-220 | 3,2 | 19,2 | 116 |

REDRYING TEMPERATURE 300-320°C/2hr