

## Dur 68 T

CATEGORY SMAW Stick Electrodes

TYPE High recovery chromium hardfacing electrode

CLASSIFICATION  
 AWS AWS A 5.13/21: E FeCr-A1  
 EN ISO 14700: E Fe14  
 DIN 8555: E 10-UM-65-GR

SUITABLE FOR Sugar mill knives and hammers, clinker crushers, sintering lines, fire gratings, mixer blades, gravel washing equipment, ceramic mixer blades, extruders etc....

APPROVALS CE approved

WELDING POSITIONS:



C	Mn	Si	Cr	Ni	Mo
3.8		0.9	33		

### ALL WELD MECHANICAL PROPERTIES

Heat Treatment	R <sub>p0,2</sub> (N/mm <sup>2</sup> )	R <sub>m</sub> (N/mm <sup>2</sup> )	A <sub>5</sub> (%)	Impact Energy (J) ISO-V			Hardness HRC
				-20°C	-40°C	-60°C	
							59

### WELDING PARAMETERS PACKING

D (mm)	Welding Parameters			Packing	
	Length (mm)	Current (A)	kg / can	kg / 6pack	
4.0	450	120-160	2.5	15	