

CATEGORY SMAW Stick Electrodes

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

APPLICATIONS hardfacing, rebuilding, overlays, machine parts, wheels, buffer layers, rails, crossings etc.

PROPERTIES Outstanding alloy against high impact combined with abrasion including metal to metal friction. The weld deposit of CEWELD E DUR 300 Kb is an exceptional easy to apply alloy without any risk for cracks and can also be applied on austenitic manganese steels, 300 HB is usually already almost obtained in the first layer. The weld deposit is machinable with tungsten tool tips. Very good weld deposit appearance and outstanding welding properties on both AC and DC+. Preheating is not required.

CLASSIFICATION
EN ISO 14700: E Fe1
DIN 8555: E 1-UM-300-P

SUITABLE FOR Rebuilding worn machine parts, Rails, Crossings, Stone crushers, Hammers, Gears, Cams, bearings, rope winches etc...

APPROVALS No Approvals Found

WELDING POSITIONS:



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	Cr
0.1	0.5	1	1.2

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	R _{p0.2} MPa	R _m MPa	A5 (%)	Hardness Brinell Hardness
As Welded /				Avg. 300

WELDING PARAMETERS / PACKING

WELDING PARAMETERS	WELDING PARAMETERS	WELDING PARAMETERS	PACKING	PACKING	PACKING
D (MM)	LENGTH (MM)	CURRENT (A)	KG / CAN	KG / 6 PACK	KG / 1000
3.2	350	95-150	2.8	16.8	36
4.0	450	140-190	3.2	19.2	66
5.0	450	190-250	3.2	19.2	116

REDRYING TEMPERATURE Not required

GAS ACCORDING EN 14175