

CATEGORY	SMAW Stick Electrodes	
TYPE	Basic coated electrode for rebuilding heat resistant machine parts and buffer layers.	
APPLICATIONS	Hardfacing, rebuilding, overlays, machine parts, wheels, conveyors, crossings, buffer layers prior to Hardfacing etc.	
PROPERTIES	Outstanding alloy against high impact combined with abrasion including metal to metal friction and increased working temperatures up to 550 °C. Due to the high resistance to cracking and toughness, all weld metal requires no buffer layer except on materials considered critical. Suited for wear parts subject to heavy impact and shock. The weld metal is machinable with carbide tip tools, hardening is possible. The maximum hardness is dependent on the base metal and is often achieved in the first layer.	
CLASSIFICATION	EN ISO DIN	14700: E Fe3 8555: E 3-UM-40-PT
SUITABLE FOR	Rebuilding worn machine parts, Stone crushers, Hammers, Gears, Cams, rails, crossings etc.	
APPROVALS	No Approvals Found	

WELDING POSITIONS:



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Mn	Cr	Mo	Si
0.1	0.6	6.5	3	0.4

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} MPa	R _m MPa	A ₅ (%)	Hardness Rockwell C
As Welded /				Avg. 40

WELDING PARAMETERS / PACKING

WELDING PARAMETERS		WELDING PARAMETERS		WELDING PARAMETERS		PACKING	PACKING	PACKING
D (MM)	LENGTH (MM)	LENGTH (MM)	CURRENT (A) (DC+/AC)	KG / CAN	KG / 6 PACK	KG / 1000		
3.2	350		95-150	2.8	16.8			
4.0	350		140-180	3.2	19.2			
5.0	450		190-250	3.4	20.4			

REDRYING TEMPERATURE	300°C / 2 hr
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GAS ACCORDING EN 14175	
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