

CATEGORY SMAW Stick Electrodes

TYPE Basic coated electrode for the application of wear resistant coatings.

APPLICATIONS Hardfacing welding and/or rebuilding of machine parts, wheels, running surfaces, sliding surfaces, impact tools, chisels, shears, shredders, pumps, etc..

PROPERTIES CEWELD® E DUR 600 KB is a basic coated electrode with approx. 130% efficiency. The electrode is characterized by its tough hard and at the same time wear resistant deposition which offers high resistance to fatigue due to pressure and impact action in combination with abrasion. The martensitic structure gives this alloy good hot strength and oxidation resistance up to about 800 °C. Excellent rolling and sliding properties in metal-to-metal wear applications, among others.

CLASSIFICATION EN ISO 14700: E Fe8
DIN 8555: E 6-UM-60-GPZ

SUITABLE FOR Reassembly of worn machine parts, rock crushers, hammers, chisels, switch shafts, cam shafts and valve tappets, pump parts, dredge buckets, cutter pistons, shredder hammers, cutting tools, chain guides, running surfaces of heavily loaded PTO shafts, etc.

APPROVALS No Approvals Found

WELDING POSITIONS:



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Mn	Cr	Mo	Nb
0.5	2.5	9	4	8.5

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	R _{p0.2} MPa	R _m MPa	A ₅ (%)	Hardness Rockwell C
As Welded /				Avg. 56

WELDING PARAMETERS / PACKING

PARAMETERS	PARAMETERS	PARAMETERS	VERPAKKING	VERPAKKING
D (MM)	LENGTE (MM)	STROOM (A) (DC+)	KG / BLIK	KG / 6 PACK
2.4	350	70-90	2.4	14.4
3.2	350/450	100-135	2.4	14.4
4.0	450	140-180	3.0	18.0
5.0	450	180-230	3.2	19.2

REDRYING TEMPERATURE 300°C / 2 hr

GAS ACCORDING EN 14175