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| CATEGORY | SMAW Stick Electrodes | |
| TYPE | Universal AC-weldable hard surfacing electrode | |
| APPLICATIONS | Suitable for deposits on mild steel, steel castings and manganese steel | |
| PROPERTIES | The electrode has a soft but intensive welding character, a fine-structured seam surface and excellent slag-removal properties | |
| CLASSIFICATION | EN ISO DIN | 14700: E Fe8 8555: E 6-UM-60-GP |
| SUITABLE FOR | Rollers, Dredger chains, Conveyors, Hammers, Dredger equipment, Mining and Earth-moving equipment | |
| APPROVALS | No Approvals Found | |

WELDING POSITIONS:



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

| C | Mn | Cr | Si |
|-----|-----|----|-----|
| 0.7 | 0.5 | 10 | 1.9 |

ALL WELD MECHANICAL PROPERTIES

| Heat Treatment | R _{p0,2} MPa | R _m MPa | A ₅ (%) | Hardness Rockwell C |
|----------------|--------------------------|-----------------------|-----------------------|------------------------|
| As Welded / | | | | Avg. 59 |

WELDING PARAMETERS / PACKING

| WELDING PARAMETERS | | WELDING PARAMETERS | | WELDING PARAMETERS | | PACKING | | PACKING | |
|--------------------|-------------|--------------------|-------------|--------------------|-------------|---------|--|---------|--|
| D (MM) | LENGTH (MM) | LENGTH (MM) | CURRENT (A) | KG / CAN | KG / 6 PACK | | | | |
| 2.5 | 350 | | 60-90 | 2.5 | 15 | | | | |
| 3.2 | 350 | | 90-120 | 2.5 | 15 | | | | |
| 4.0 | 450 | | 110-160 | 3 | 18 | | | | |
| 5.0 | 450 | | 150-200 | 3 | 18 | | | | |

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| REDRYING TEMPERATURE | 350°C / 2 hr |
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| GAS ACCORDING EN 14175 | |
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