

CATEGORY	SMAW Stick Electrodes	
TYPE	Stick Electrodes with a Iron based tubular core wire with tungsten carbides	
APPLICATIONS	Mining, Concrete recycling, drilling	
PROPERTIES	High resistance against wear	
CLASSIFICATION	EN ISO	14700: E Fe20
SUITABLE FOR	Hardfacing drill points, Augers, Impellers, Mixer blades, Stone crushing equipment, Deep drilling,	
APPROVALS	No Approvals Found	

WELDING POSITIONS:



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Fe
3.7	40

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} MPa	R _m MPa	A ₅ (%)	Hardness Vickers
As Welded /				Avg. 60
As Welded /				Avg. 2000

WELDING PARAMETERS / PACKING

WELDING PARAMETERS	WELDING PARAMETERS	WELDING PARAMETERS	PACKING	PACKING	PACKING
D (MM)	LENGTH (MM)	CURRENT (A)	KG / CAN	KG / 6PACK	KG / 1000

REDRYING TEMPERATURE	Not required
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GAS ACCORDING EN 14175	
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