

Standards

TS 9463 EN ISO 1071	: E C Z Fe-1
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AWS A5.15	: E St

Mechanical Properties

Hardness (cast iron) (HRC)
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Features and Applications

- Electrode with steel core
- Uses in suriacing of particularly high-hardness zones in cast iron materials
- High hardness, allowing direct application without a buffer layer on cast irons
- Specific applicability in surfacing of cast iron moulds used in the automotive industry, at radii, of deep drawing dies, and of casting edges
- Excellent results obtained in suriacing of launders for spherocasting as well as in hardfacing applications of cast iron materials
- Steady behavior of welding and arc start with almost no spattering

Welding Positions



Current Type

D.C.(+) / AC

Operating Data

Product Code	Diameter x Length (mm) / (inch)		Welding Current (A)	Package Weight (Kg)	Weight g / 100 pcs
3030100010	2.50 x 350	3/32 x 14"	70-100	5	1852
3030100011	3.20 x 350	1/8 x 14"	80-130	5	3100

Approvals: GOST-R, CE, SEPRO