

### Standards

TS EN 14700	: E Fe 1
EN 14700	: E Fe 1
DIN 8555	: E 1 - UM - 300

### Mechanical Properties

<b>Hardness</b> (HB)
325 - 350

### Features and Applications

- Weld metal has high machinability and high efficiency
- Risk of cracking is very low
- Used in joining of high tensile strength steels, some parts exposed to impact and abraision as a buffering and filler electrode
- Rails, switches and crossings, ladles, gear parts, crane wheels are typical application areas of this electrode

### Welding Positions



### Flux Cored Wire

GeKaTec HARDCOR 300 G

GeKaTec HARDCOR 300 O

### Current Type

D.C.(+) / AC

### Operating Data

Product Code	Diameter x Length (mm) / (inch)		Welding Current (A)	Package Weight (Kg)	Weight g / 100 pcs
3030100052	3.20 x 350	1/8 x 14"	100-140	5	3645
3030100053	4.00 x 350	5/32 x 14 "	140-180	5	5300

**Approvals:** GOST-R, CE, SEPRO