

### Standards

TS EN 14700	: E Fe 9
EN 14700	: E Fe 9
DIN 8555	: E 7-UM-250KP

### Mechanical Properties

Hardness (HB)	
As Welded	After Working
250	550

### Features and Applications

- Suitability for uses in hardfacing of high-manganese steels
- Most common applications in hardfacing of various equipment parts that are exposed to deep impacts, pressure and wearing in cement, mining and earth-moving industries
- High resistance to impact and to friction
- Increasing hardness of weld metal after operations including its exposure to impact and friction.
- High toughness
- Requirement of electrode holding in perpendicular direction to work piece, by maintaining short and uniform - exposed arc
- Requirement of two-pass buffer-layering with the electrode GeKaTec 660 HD for providing good connection and crack protection in case of thick-layer hardfacing operations
- Requirement of re-drying at 300°C for 2 hours

### Welding Positions



### Flux Cored Wire

GeKaTec HARDCOR 660 0

### Current Type

D.C.(+) / AC

### Operating Data

Product Code	Diameter x Length (mm) / (inch)		Welding Current (A)	Package Weight (Kg)	Weight g / 100 pcs
3030100050	3.20 X 350	1/8 X 14"	110-140	5	4790
3030100051	4.00 X 350	5/32 X 14"	150-180	5	7320

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