

**Standards**

TS EN 14700	: E Z Fe 9
EN 14700	: E Z Fe 9
DIN 8555	: E 7-UM-200K
AWS A5.13	: E FeMn-A

**Chemical Composition of  
Weld Metal % (Typical)**

C	Mn	Si	Ni
0.6	13.5	0.1	3.0

**Mechanical Properties**

Hardness (HB)	Hardness After Cold Deformation (HB)
180 - 220	~ 550

**Features and Applications**

- Hardfacing of mining and rock-crushing machine parts as well as of hard manganese steels.
- Machinability of weld metal only if it is not hammered when it is cold, or, if it is not put into operation for a while
- Re-drying at condition 300°C / 2h is required

**Resistance Type and Level**

Friction



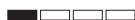
Impact



High Temp.



Thermo Shock



Corrosive



Crack Resistance



Machining


**Current Type**

D.C.(+)

**Operating Data**

Product Code	Diameter x Length (mm) / (inch)		Welding Current (A)	Weight g / 100 pcs
3010101876	3.20 x 350	1/8 x 14"	110 - 140	3700
3010101882	4.00 x 450	5/32 x 18"	150 - 180	6870
3010101885	5.00 x 450	3/16 x 18"	180 - 210	10900

**Approvals:** SEPRO