

Standards

TS EN 14700	: E Fe 1
EN 14700	: E Fe 1
DIN 8555	: E1-UM-250

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

C	Mn	Si	Cr
0.15	1.0	0.8	1.0

Mechanical Properties

Weld Metal Hardness (HB)
240 - 280

Features and Applications

- For tough build-ups on rails, gearwheels, shafts, gear parts, and couplings
- For buffer layers on carbon steels and low-alloyed steels with concurrent extreme compressive stress on anti-wear surfaces
- Re-drying: 300°C / 2h

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
3010101744	3.20 x 350	1/8 x 14"	100 - 140	3670
3010101747	4.00 x 450	5/32 x 18"	140 - 180	6820
3010101750	5.00 x 450	3/16 x 18"	180 - 230	10570

Approvals: SEPRO