

Standards

TS EN 14700	: E Fe 1
EN 14700	: E Fe 1
DIN 8555	: E1-UM-300

Chemical Composition of Weld Metal % (Typical)

C	Mn	Si	Cr
0.15	1.3	0.5	1.5

Mechanical Properties

Weld Metal Hardness (HB)
280 - 330

Features and Applications

- Basic coated electrode for medium hardness value
- For tough build-ups, particularly on Mn-Mo-alloyed wing and junction rails with mechanical strength of minimum 880 N/mm²
- Deposit offers ease of machining
- Pre-heating temperature 250°C-350°C.
- 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
3010101753	3.20 x 350	1/8 x 14"	100 - 140	3571
3010101759	4.00 x 450	5/32 x 18"	140 - 180	6775
3010101762	5.00 x 450	3/16 x 18"	180 - 230	10500

Approvals: SEPRO