

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
0.14	0.5	0.5	1.8

Mechanical Properties

Weld Metal Hardness (HB)	Weld Metal Hardness (HB) 900°C/cooled on water/tempered
300 - 330	450 - 470

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
- It can use with alternating current
- 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.(+) / A.C.

Operating Data

Product Code	Diameter x Length (mm) / (inch)		Welding Current (A)	Weight g / 100 pcs
3010101765	3.20 x 350	1/8x 14"	90 - 135	3520
3010101768	4.00 x 450	5/32 x 18"	135 - 180	6690

Approvals: SEPRO