

Standards

TS EN 14700	: E Fe 1
EN 14700	: E Fe 1
DIN 8555	: E1-UM-350

Chemical Composition of Weld Metal % (Typical)

C	Mn	Si	Cr
0.17	1.5	0.8	2.0

Mechanical Properties

Weld Metal Hardness (HB)
330 - 380

Features and Applications

- Basic-coated electrode
- Wear resistant surfacing on Mn-Cr-V alloyed frogs, track rollers, idlers, tracks, slideways and drive sprockets
- The deposits are machinable
- Re-drying: 300°C / 2h

Resistance Type and Level

Friction	High Temp.	Corrosive	Machining
■■■■□□	■■■■□□	■■■■□□	■■■■■■
Impact	Thermo Shock	Crack Resistance	
■■■■■■	■■■■□□	■■■■■■	

Current Type

D.C.(+)

Operating Data

Product Code	Diameter x Length (mm) / (inch)		Welding Current (A)	Weight g / 100 pcs
3010101774	3.20 x 350	1/8 x 14"	100 - 140	3600
3010101777	4.00 x 450	5/32 x 18"	140 - 180	6750
3010101780	5.00 x 450	3/16 x 18"	180 - 230	10540

Approvals: SEPRO