

### Standards

TS EN 14700	: E Z Fe 1
EN 14700	: E Z Fe 1
DIN 8555	: E1-UM-50

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

C	Mn	Si	Cr
0.3	1.3	1.2	~5.5

### Mechanical Properties

Weld Metal Hardness (HRC)
~50

### Features and Applications

- Used in hardfacing applications of guide roller, rope pulleys, ladle lugs etc. for land, mineral and coal sector
- Weld metal has strength against friction and wear
- Pre-heating is generally 200°C according to base material
- 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
3010101792	3.20 x 350	1/8 x 14"	100 - 140	3600
3010101798	4.00 x 450	5/32 x 18"	140 - 180	7010
3010101804	5.00 x 450	3/16 x 18"	180 - 230	10900

Approvals: SEPRO