

Standards

TS EN 14700	: E Fe 4
EN 14700	: E Fe 4
DIN 8555	: ~E 4-UM-60

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

C	Mn	Si	Mo	Co	V	Cr
0.7	1.0	1.0	7.0	2.0	1.7	4.0

Mechanical Properties

Hardness (HRC)
56 - 60

Features and Applications

- Used in repairing of machining and cutting tools, tool bits, press dies and supports, fillers against strong abrasion of excavating and detaching attachments
- Weld deposit has high resistance to friction and wear
- Re-drying: 300°C-350°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
3010101933	3.20 x 350	1/8 x 14"	80-110	4410
3010101936	4.00 x 350	5/32 x 14"	110-140	5960

Approvals: SEPRO