

Standards

TS EN 14700	: E Fe 8
EN 14700	: E Fe 8
DIN 8555	: E6-UM-60 P

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

C	Mn	Si	Mo	V	Cr
0.5	0.5	1.1	1.0	1.0	7.5

Mechanical Properties

Weld Metal Hardness (HRC)	780- 820 °C Cooling in Furnace	Hardening 1000 - 1050°C in Oil	300 - 400°C Tempered
55-59	~ 25 HRC	~60 HRC	53 - 55 HRC

Features and Applications

- Final pass-welding of parts of earth-moving and mining equipment with high resistance to abrasion, as well as of parts of hard manganese steels and frags
- Weld metal is resistant to abrasion
- 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
3010101810	3.20 x 350	1/8 x 14"	100 - 140	3660
3010101813	4.00 x 450	5/32 x 18"	140 - 180	6820
3010101816	5.00 x 450	5/16 x 18"	180 - 230	10500

Approvals: SEPRO