

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	0.3	1.1	1.0	1.0	7.0

Mechanical Properties

Weld Metal Hardness (HRC)
55 - 59

Features and Applications

- Electrode covering of rutile character
- Usability with a welding transformer (Weldability with AC)
- Weld metal with ductile and cracking-resistant behaviors
- Requirement of re-drying at the temperature range of 300°C-350°C for 2 hours
- Applicability in final layer welding of earth and mineral mining machines. Impact drilling and crushing devices, guide springs, edges of cutting tools, hard manganese steels, bucket edges and teeth

Resistance Type and Level

Friction



High Temp.



Corrosive



Machining



Impact



Thermo Shock



Crack Resistance


Current Type

D.C.(+) / A.C.

Operating Data

Product Code	Diameter x Length (mm) / (inch)		Welding Current (A)	Weight g / 100 pcs
3010101831	3.20 x 350	1/8 x 14"	90 - 135	4170
3010101834	4.00 x 450	5/32 x 18"	135 - 180	7640
3010101837	5.00 x 450	3/16 x 18"	180 - 230	11670

Approvals: SEPRO