

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	Cr	Si
0.5	9.0	1.8

Mechanical Properties

Weld Metal Hardness (HRC)	Slow Cooling in Furnace	Hardening 1000 - 1050°C in Oil	Tempered 300-400°C
54 - 58	780-820°C	~60 HRC	53 - 55 HRC

Features and Applications

- Applicability in final-layer hardfacing of parts of earth and mineral mining machines, impact drilling and crushing devices, guide springs, edges of cutting tools, hard manganese steels, bucket edges and teeth, all of which are made of alloyed or unalloyed steels, as well as in other materials required to have high resistance to wear
- Electrode of basic type with thick coating
- Inclusion of chromium-silicon alloy, very hard electrode
- Weld metal with ductile and cracking-resistant behaviors: Crack resistance to impact forcing due to its high ductility: Machinability of weld metal through grinding only: Requirement of re-drying at 300°C for 2 hours for moistened electrodes: Recommended pre-heating at 200-300°C for welding thick work pieces and materials tending to get hardened: Requirement of 2-3 layers hardfacing to obtain the highest resistance to wear
- Suitability of harder and/or higher-quality steels to buffer-layering with the GeKa electrodes LASER B 50, TEMPO B 63, or, in some cases, with the GeKa electrodes such as ELOX B307, ELOX R 312
- 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
3010101822	3.20 x 350	1/8 x 14"	100 - 140	3650
3010101825	4.00 x 450	5/32 x 18"	140 - 180	6840
3010101828	5.00 x 450	3/16 x 18"	180 - 230	10900

Approvals: SEPRO