

Standards

TS EN 14700	: E Fe 6
EN 14700	: E Fe 6
DIN 8555	: E6-UM-60

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

C	Mn	Si	Mo	Nb	Cr
0.55	1.35	0.75	1.2	0.6	6.8

Mechanical Properties

Weld Metal Hardness (HRC)
56 - 59

Features and Applications

- Used in hardfacing applications of earth-moving industry and wearing parts of grinders etc.
- Can be used directly. After three or more passes, buffer-layering must be done according to material grade. (ELHARD 63, ELHARD 250, ELOX R 307 and ELHARD 14 Mn)
- For hardenable steels, preheat temperature is 100-300°C
- 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
3010100333	3.20 x 350	1/8 x 14"	100 - 140	3846
3010101846	4.00 x 450	5/32 x 18"	140 - 180	6930
3010101849	5.00 x 450	3/16 x 18"	180 - 230	10900

Approvals: SEPRO