

Standards

TS EN 14700	: E Fe 2
EN 14700	: E Fe 2
DIN 8555	: ~E6-UM-60

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

C	Mn	Si	Mo	V	Cr
0.5	1.5	1.2	0.8	0.8	4.7

Mechanical Properties

Weld Metal Hardness (HRC)
60 - 62

Features and Applications

- Hardfacing of workpieces of steel, cast steel or hard Mn-steel exposed to a combination of impact, compression and abrasive wearing, such as cam shafts, gliding surfaces, gears, plough shares, rails, shunts, crosses, baffle plates, excavator parts, rope carrier wheels etc.
- Weld metal does not cracking
- 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.(+)

Operating Data

Product Code	Diameter x Length (mm) / (inch)		Welding Current (A)	Weight g / 100 pcs
3010101861	3.20 x 350	1/8 x 14"	100 - 150	3920
3010101867	4.00 x 450	5/32 x 18"	140 - 180	7790
3010101870	5.00 x 450	3/16 x 18"	170 - 210	10750

Approvals: SEPRO