

Standards

TS EN 14700	: E Co 1
DIN 8555	: E 20-UM-300-CKTL

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

C	Mo	Co	Cr	Ni
0.3	5.6	Rest	26.0	3.0

Mechanical Properties

Hardness (HRC)	
After Welding	After Working
30 - 32	45

Features and Applications

- It is used for hardfacing of materials subject to impact, pressure, abrasion, corrosion and high temperature or combination of these
- Die molds, extruder, screws, hot cutting and working boiler steels, shafts, pumps, valves and seats
- Weld metal has work hardening ability under impact and friction
- Before welding, it must be buffering with 307 and 309 electrodes

Resistance Type and Level

Friction



Impact



High Temp.



Thermo Shock



Corrosive



Crack Resistance



Machining


Current Type

D.C.(+)/ AC

Operating Data

Product Code	Diameter x Length (mm) / (inch)		Welding Current (A)	Package Weight (Kg)	Weight g / 100 pcs
3030100070	3.20 x 350	1/8 x 14"	90 - 120	5	3500

Approvals: SEPRO