

### Standards

|             |                 |
|-------------|-----------------|
| TS EN 14700 | : E Z Fe 8      |
| EN 14700    | : E Z Fe 8      |
| DIN 8555    | : E 3-UM-50 GTZ |

### Mechanical Properties

| Hardness (HRC) |                      |
|----------------|----------------------|
| As Welded      | After Heat Treatment |
| 45 - 50        | 48 - 54              |

### Features and Applications

- Include spining rotors, for glass-wool production, draw plates, stamping trimming dies, klin parts, pump shafts, chucks etc
- Manuel electrode for anti-wear protective coatings on tool-steel parts working under very hot or cold conditions
- Electrode with Co, Cr, Mo alloys gives excellent metal / metal friction resistance at high temperatures
- Ideal for use as surfacing with no risk of cracking

### Resistance Type and Level

|          |              |                  |           |
|----------|--------------|------------------|-----------|
| Friction | High Temp.   | Corrosive        | Machining |
| ■■■■■    | ■■■■□        | ■■■■□            | ■■■■□     |
| Impact   | Thermo Shock | Crack Resistance |           |
| ■■■■■    | ■■■■□        | ■■■■□            |           |

### Flux Cored Wire

GeKaTec HARDCOR 50 G

### Current Type

D.C.(+)

### Operating Data

| Product Code | Diameter x Length<br>(mm) / (inch) |            | Welding Current<br>(A) | Package Weight (Kg) | Weight<br>g / 100 pcs |
|--------------|------------------------------------|------------|------------------------|---------------------|-----------------------|
| 3030100073   | 2.50 x 250                         | 3/32 x 10" | 75                     | 4                   | 1600                  |
| 3030100074   | 3.20 x 350                         | 1/8 x 14"  | 110                    | 5                   | 3680                  |

Approvals: SEPRO