

Standards

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| DIN 8555 | : E 3-UM-60 ST |
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Mechanical Properties

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| Hardness (after working) (HRC) |
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| 58 |
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Features and Applications

- A special kind of rutile-coated electrode for hardfacing of hot- and cold-work tool steels.
- Suitability for uses in hardfacing of hot or cold-work steels, edges of cutting dies, blades of hot-shearing machines, punching tools, rolls and impact punches, machinery tools for die-casting; at temperatures up to 550°C
- Applicability in hardfacing of steel materials such as ST50, ST60, ST70 as well as in re-manufacturing of tools
- Requirements of pre-annealing at 400°C of the base metal, welding through hammering, not exceeding the pre-annealing temperature by welding, and of very slow cooling of weld metal
- Variability of weld metal's hardness through heat treatment

Resistance Type and Level

Friction



Impact



High Temp.



Thermo Shock



Corrosive



Crack Resistance



Machining



MIG Wire

GeKaTec TOOL 55 SG

Current Type

D.C.(-) / AC

Operating Data

| Product Code | Diameter x Length (mm) / (inch) | | Welding Current (A) | Package Weight (Kg) | Weight g / 100 pcs |
|--------------|------------------------------------|------------|------------------------|---------------------|-----------------------|
| 3030100084 | 2.50 x 350 | 3/32 x 14" | 50 - 70 | 4 | 2070 |
| 3030100085 | 3.20 x 350 | 1/8 x 14" | 90 - 120 | 5 | 3270 |

Approvals: SEPRO