

Standards :

TS EN 14700	:	E Fe 1
EN 14700	:	E Fe 1
DIN 8555	:	E 1-UM-250

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

C	Mn	Si	Cr
0.15	1.0	0.8	1.0

Mechanical Properties :

Weld Metal Hardness (HB)
240 - 280

Typical Base Material Grades :

* For tough build-ups on rails, gearwheels, shafts, gear parts, and couplings.

*For buffer layers on carbon steels and low-alloyed steels with concurrent extreme compressive stress on anti-wear surfaces.

* Re-drying : 300 °C / 2h

Welding Positions :



Current Type :

D.C.(+)

Operating Data :

Diameter x Length (mm)	Diameter x Length (inch)	Welding Current (A)	Weight g /100 pcs
3.20 x 350	1/8 x 14"	100 - 140	3670
4.00 x 450	5/32 x 18"	140 - 180	6820
5.00 x 450	3/16 x 18"	180 - 230	10570

Approvals :

CE, GOST-R, SEPRO