

Standards :

TS EN 14700	:	E Fe 1
EN 14700	:	E Fe 1
DIN 8555	:	E1-UM-300

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

C	Mn	Si	Cr
0.15	1.3	0.5	1.5

Mechanical Properties :

Weld Metal Hardness (HB)
280 - 330

Typical Base Material Grades :

- * Basic coated electrode for medium hardness value.
- * For tough build-ups, particularly on Mn-Mo-alloyed wing and junction rails with mechanical strength of minimum 880 N/mm². * Deposit offers ease of machining.
- * Pre-heating temperature 250-350°C.
- * Re-drying : 300°C / 2 h

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	3650
4.00 x 450	5/32 x 18"	140 - 180	6775
5.00 x 450	3/16 x 18"	180 - 230	10500

Approvals :

CE, GOST-R, SEPRO