

Standards :

TS EN 14700	:	E Fe 1
EN 14700	:	E Fe 1
DIN 8555	:	E1-UM-350

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

C	Mn	Si	Cr
0.17	1.5	0.8	2.0

Mechanical Properties :

Weld Metal Hardness (HB)
330 - 380

Typical Base Material Grades :

- * Basic-coated electrode.
- * Wear resistant surfacing on Mn-Cr-V alloyed frogs, track rollers, idlers, tracks, slideways and drive sprockets.
- * The deposits are machinable.
- * 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	3600
4.00 x 350	5/32 x 18"	140 - 180	6790
5.00 x 450	3/16 x 18"	180 - 230	10540

Approvals :

CE, GOST-R, SEPRO