

Standards :

TS EN 14700	:	E Z Fe 1
EN 14700	:	E Z Fe 1
DIN 8555	:	E1-UM-50

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

C	Mn	Si	Cr
0.3	1.3	1.2	~5.5

Mechanical Properties :

Weld Metal Hardness (HRC)
-50

Typical Base Material Grades :

- * Basic-coated electrode.
- * For surfacing especially hard, abrasion- and impact-resistant materials that can be hardened too.
- * In earth-moving and rock-crushing machinery parts (universal application)
- * 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	7010
5.00 x 350	3/16 x 14"	180 - 230	7950

Approvals :

CE, GOST-R, SEPRO