

Standards :

TS EN 14700	:	E Fe 14
EN 14700	:	E Fe 14
DIN 8555	:	E 10-UM-60 GRZ

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

C	Mn	Si	Cr
3.20	0.5	1.0	29.0

Mechanical Properties :

Hardness (HRC)
58 - 62

Typical Base Material Grades :

- * On parts primarily exposed to abrasion combined with light impact, such as conveyor screws, mixer blades and mud pumps.
- * As final layer on tough-hard weld deposits or high-Mn Steels.
- * Requirement of re-drying for 2 hours at the temperatures between 300 °C and 350 °C.

Welding Positions :



Current Type :

- D.C.(+)
- A.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"	110 - 140	4810
4.00 x 350	5/32 x 14"	140 - 170	7960
5.00 x 350	3/16 x 14"	170 - 210	11400

Approvals :

CE, GOST-R, SEPRO