

**Standards :**

TS EN 14700	:	E Fe 8
EN 14700	:	E Fe 8
DIN 8555	:	E6-UM-60 P

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

C	Mn	Si	Mo	V	Cr
0.5	0.5	1.1	1.0	1.0	7.5

**Mechanical Properties :**

Weld Metal Hardness (HRC)	780 - 820°C Cooling in Furnace	1000 - 1050°C Hardening in Oil	300 - 400°C Tempered
55 - 59	~250 HB	~60 HRC	~53 - 55 HRC

**Typical Base Material Grades :**

- \* Final pass-welding of parts of earth-moving and mining equipment with high resistance to abraision, as well as of parts of hard manganese steels and frags.
- \* Weld metal is resistant to abraision.
- \* 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
2.50 x 350	3/32 x 14"	60 - 100	2430
3.20 x 350	1/8 x 14"	100 - 140	3720
4.00 x 450	5/32 x 18"	140 - 180	7170
5.00 x 450	5/32 x 18"	180 - 230	10900

**Approvals :**

CE, GOST-R, SEPRO