

Standards :

TS EN 14700	:	E Fe 6
EN 14700	:	E Fe 6
DIN 8555	:	E6-UM-60

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

C	Mn	Si	Mo	Nb	Cr
0.55	1.35	0.75	1.2	0.6	6.8

Mechanical Properties :

Weld Metal Hardness (HRC)
56

Typical Base Material Grades :

- * Surfacing of structural parts exposed to abrasion combined with impact.
- * Hardfacing of tools in the earth-moving industry and crushing plants as well as cold working tools.
- * Machinability of weld deposit by grinding only.
- * Requirement for re-drying at 300 °C for 2 hours.

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	3700
4.00 x 450	5/32 x 18"	140 - 180	6760
5.00 x 450	3/16 x 18"	180 - 230	10750

Approvals :

CE, GOST-R, SEPRO