

Processing information

Re-drying: 200 - 250 °C/2 h
(if required)

Welding positions:



Polarity:



To avoid cracks preheating up to min.
500 °C, slow down cooling necessary.

Application

High-performance electrode for surfacings on tools and machine parts which are exposed to extreme abrasion under high temperatures. This stick electrode is suitable for surfacings and repairs in the coal mining industry, in mineral and cement processing and in the steel industry.

Field



Characteristic
rutile-coated,
240 % recovery

Standards
DIN EN 14700
E Fe16
DIN 8555
E 10-UM-70 GRC

All Weld Metal Mechanical Properties

Weld Metal Composition [%]

C	Si	Mn	Cr	B
4,8	0,7	0,5	38	3

Hardness [HRC]

As-welded	68 - 70
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Welding Current, Packaging

Item no.	Dm./Länge [mm]	Amperage [A]	kg/Pack	= Piece/Pack	kg/1000 Pc.
00.627.323	3,25/350	120 - 160	5,0	86	58,1
00.627.404	4,00/450	150 - 190	6,0	54	111,1
00.627.504	5,00/450	200 - 250	6,0	34	176,5



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