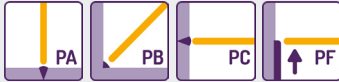


Processing information

Re-drying: 300 – 350 °C/2 h

Welding positions:



Polarity:



Massive components from unalloyed, crack-sensitive steels with higher carbon content need to be pre-heated to 250–350 °C.

Application

Electrode for surfacing on machine parts made from unalloyed and low-alloyed metals and which are subject to roll and rolling contact wear with dragged or crushing load, e.g. railways, switch parts, running wheels and runways, worms, shafts, gear parts, etc. The weld metal is still machinable.

All Weld Metal Mechanical Properties

Weld Metal Composition [%]

C	Si	Mn	Cr
0,15	0,7	1	1,8

Hardness [HB]

As-welded	280 – 340
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Field



**Characteristic
basic-coated**

**Standards
DIN EN 14700
E Fe1
DIN 8555
E 1-UM-350**

Approvals



Welding Current, Packaging

Item no.	Dm./Länge [mm]	Amperage [A]	kg/Pack	≈ Piece/Pack	kg/1000 Pc.
00.649.323	3,25/350	110 – 140	5,0	130	36,2
00.649.404	4,00/450	140 – 180	6,0	80	70,6
00.649.504	5,00/450	180 – 240	6,0	51	117,6



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