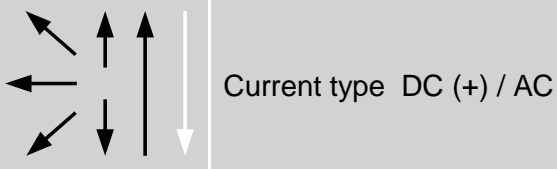


Classifications					
EN ISO 3581-A		EN 14700		AWS A5.4	
E 18 8 Mn R 32		E Fe10		E307-16	
Characteristics and field of use					
<p>Non alloy structural and heat treatable steels can be welded, also in combination with austenitic CrNi steels. Universally applicable for surfacing of work pieces exposed to impact, pressure and rolling wear. Such as curved rails, crusher parts, and excavator teeth. Provides crack-proof buffer layers under hard alloys. Weld deposit resist to scaling, rust and cracks, work hardened.</p> <p>Hardness of the pure weld metal As welded : 190 HB After work hardened : 250 HB</p>					
Typical analysis of all weld metal (Wt.-%)					
C	Si	Mn	Cr	Ni	Fe
0.1	0.8	5.0	19.0	8.5	Balance
Mechanical properties of the weld metal					
Yield strength $R_{P0,2}$		Tensile strength R_m		Elongation A	
MPa		MPa		%	
> 350		> 600		> 40	
				Impact strength K_V (J)	
				+ 20°C	
				60	
Welding instruction					
<p>Clean welding area. Pre-heating of thick wall ferritic part to 150°C - 250°C. Hold the stick electrode vertically with short arc. Re-dry stick electrode before use at 250 - 350°C at 2 hrs.</p>					
Welding positions					
					
Approvals					
-					
Size, Packing and Recommended welding parameters					
Size mm		Kg / Pack		Kg / Box	
Amperage (A)					
2.50 x 350		4.6		18.4	
3.25 x 350		5.0		20.0	
4.00 x 350		5.0		20.0	
5.00 x 450		6.2		24.8	
				50 – 70	
				70 – 100	
				100 – 130	
				150 – 180	