

Classifications

| DIN 8555 | EN 14700 | AWS A5.13 |
|----------------|----------|-----------|
| E 10-UM-60-GRZ | E Fe 14 | E FeCr-A8 |

Characteristics and field of use

- ◆ Chromium carbide deposits suited for highly wear resistant claddings on part subjected to grinding abrasion combined with medium impact such as conveyor screws, scraper blades, digging teeth, mixer wings, crusher hummers and rotors.
- ◆ Excellent welding characteristic and easy slag removal.

Typical analysis of all weld metal (Wt.-%)

| C | Si | Cr | Fe |
|-----|-----|----|---------|
| 3.2 | 1.2 | 30 | Balance |

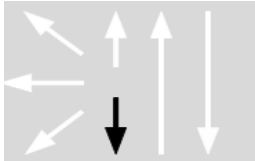
Mechanical properties of the weld metal

| | |
|-----------------------------------|----------------|
| Hardness of the pure weld deposit | Approx. 60 HRC |
| 1 layer on steel with C = 0.15% | Approx. 55 HRC |
| 1 layer on high Mn-steel | Approx. 52 HRC |

Welding Instruction

Hold stick electrode as vertically as possible, keep a short arc. Preheating is in general not necessary. On multipass applications a cushion layer with UTP S DUR 250 / UTP S DUR 350 / UTP S 63 / UTP S BMC is recommended.

Welding Position



Current type DC (+) / AC

Approval

-

Size, Packing and Recommended welding parameters

| Size (mm) | Kg / Pack | Kg / Box | Amperage (A) |
|------------|-----------|----------|--------------|
| 3.25 x 350 | 4.4 | 17.6 | 90 - 130 |
| 4.00 x 450 | 5.6 | 22.4 | 130 - 180 |
| 5.00 x 450 | 6.2 | 24.8 | 140 - 190 |