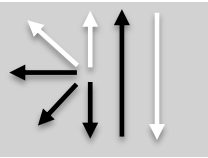


Classifications				
DIN 8555		EN 14700		
E 7-UM-250-KPR		E Fe9		
Characteristics and field of use				
<ul style="list-style-type: none"> <li>➤ Suitable for build-up and claddings on part subject to highest pressure and shock in combination with abrasion.</li> <li>➤ Surfacing can be made on ferritic steel as well as austenitic hard Mn-steel and joints on hard Mn-steel can be welded.</li> <li>➤ Main application are in the mining, cement, crushing plant, steel works, thermal power plant where working parts are regenerated, such as breaker jaws, frogs, cross pieces, paving breakers, crusher hammer &amp; rotors, railway points &amp; crossing, etc.</li> <li>➤ Rapid work hardening and high toughness.</li> </ul> <p>Hardness of the pure weld metal            As welded : 260 HB            After work hardened : 48-53 HRC</p>				
Typical analysis of all weld metal (Wt.-%)				
C	Si	Mn	Cr	Fe
0.70	0.70	15.0	12.0	Balance
Welding instruction				
<p>Hold the stick electrode nearly vertical. Welding should be done at low temperature. Interpass temperature should not exceed 250°C. it is therefore recommended to weld short beads and to allow for continuous cooling or to replace the workpiece in a cold water bath with only the welding area sticking out of water. Re-drying 2 hours at 300°C.</p>				
Welding positions				
 <p>Current type DC (+) / AC</p>				
Approvals				
-				
Size, Packing and Recommended welding parameters				
Size mm	Kg / Pack	Kg / Box	Amperage (A)	
3.25 x 350	5.0	20.0	110 – 150	
4.00 x 450	4.6	18.4	140 – 190	
5.00 x 450	5.8	23.2	190 – 240	