

SUPRADUR 600RB is a thick basic coated high-efficiency MMA electrode.

Typical applications include hardfacing subject to abrasion, e.g. civil works and mining equipment, shovel teeth, buckets and crawler shoes.

Used for hardfacing carbon steels and low alloy steels against abrasion by minerals and subject to impact, weld metal hardness~57-62HRC. Can only be machined by grinding. When welding crack sensitive base materials or every third layer in case of thick deposit, a buffer layer is required using more ductile unalloyed basic or 307 type MMA electrode. Excellent weldability in all position except vertical down and overhead positions. Shall be used in DC+ or AC mode.

Classification	
EN ISO	14700: E Z (Fe2)
DIN	8555: E 6-UM-60

Approvals	Grade
DB	●
CE	

Chemical analysis (Typical values in %)

C	Mn	Si	Cr	Mo	Fe	V
0.5	0.5	0.8	7	0.5	Rem	0.7

All-weld metal Mechanical Properties

Heat Treatment	Hardness
As Welded	57-62 HRC

Storage

Keep dry and avoid condensation.

Re-drying not generally required.

If necessary: 100-150°C for 1 hour, 5 times max.

Current condition and welding position

AC; DC+



Packaging data

Diam. (mm)	Length (mm)	Current (A)	Approx. weightn(kg/1000)	CBOX		SMPA	
				PC	Code	PC	Code
2.5	350	65-90	19.2	270	W000258541	35	W000288157
3.2	350	100-130	33.4	160	W000258542	22	W000288158
4.0	350	140-160	47.9	105	W000258543		
5.0	450	160-210	99.5	60	W000258544		