

E DUR 60 Kb

CATEGORY SMAW Stick Electrodes

TYPE Basic coated, alloyed Cr-Mo-V electrode

APPLICATIONS Hardfacing against high impact combined with strong abrasion wear.

PROPERTIES Outstanding alloy against high impact combined with abrasion including metal into metal friction. The weld deposit of CEWELD E Dur 60 Kb is one of the most universal alloys in hardfacing applications and can also be applied on austenitic manganese steels. Very good weld deposit appearance and outstanding welding properties on both AC and DC+. Preheating is not required.

CLASSIFICATION

AWS	A 5.13:~E Fe3 F-No. 71
EN ISO	14700: E Fe8
DIN: W.Nr.	1.4718
DIN	8555: E6-UM-60

SUITABLE FOR Mixing arms, cold cutting tools, hammers, rolls, loaders, buckets, pumps, hardfacing on austenitic manganese steel, rebuilding knives

APPROVALS CE approved

WELDING POSITIONS:



WELD METAL ANALYSIS %

C	Cr	Mn	Mo	V	Fe
0.5-0.8	7-10	0.5-0.7	0.5-1.0	1.0-1.2	rem

MECHANICAL PROPERTIES

Heat treatment	Hardness RT
AW	54-60 HRC

AW: as welded

WELDING PARAMETERS / PACKING

D (mm)	Welding Parameters			Packing	
	Length (mm)	Current (A)	kg / can	kg / 6 pack	kg / 1000
2.5	350	80-120	3.00	18.00	
3.2	450	100-160	3.30	19.80	
4.0	450	160-220	3.50	21.00	
5.0	450	190-260	3.30	18.00	

REDRYING TEMPERATURE 300°C/2hr

EQUIVALENTS GMAW - CEWELD MA 600