

DURWELD 300

Electrodes MMA [SMAW]

Hardfacing and repairing

CLASSIFICATION:	APPROVALS:	APPLICATION:
EN ISO 14700-A : E Fe3 DIN 8555 : E 1-UM-300 P	UDT	Hardfacing and repairing

- Hardfacing electrode with Cr.
- Excellent slag release, low spatter.
- The joint is covered with an uniform, very fine scale.
- For the regeneration of elements exposed to high impact and medium abrasion.
- Recommended for surfacing parts exposed to wear.

Application

Road wheels, gear wheels, chain links, rails, rolling mill components, couplings, etc.



Base material

Steel
Cast steels

Typical chemical composition %

C	Mn	Cr
0,18	1,00	1,20

Typical mechanical properties

Hardness	275 - 325 HB / The hardness of the overlay depends on the relevant welding conditions, the number of layers and the chemical composition of the base material. /
Coating type	basic
Welding current	
Welding positions	
Redrying	400°C / 1 h lub 300°C / 2 h

Welding parameters and packing

∅	Length [mm]	Welding current [A]	Weight of packet [kg]	Weight of carton [kg]	Pcs/1 kg
2,5	350 /	70-90	4,0	12,0	60
3,2	350 /	100-135	4,5	13,5	28
4,0	450 /	130-170	5,5	16,5	14
5,0	450 /	180-220	5,5	16,5	9