

DURWELD 600

Electrodes MMA [SMAW]

Hardfacing and repairing

CLASSIFICATION:	APPROVALS:	APPLICATION:
EN ISO 14700-A : E Fe8 DIN 8555 : E 6-UM-60 P	UDT	Hardfacing and repairing

- Electrode for hardfacing steel elements exposed to high impact.
- Excellent slag release, low spatter.
- The joint is covered with an uniform, very fine scale.
- Overlay with a hardness of 57-62 HRC, with medium resistance to abrasion.
- For hardfacing of parts exposed to high impact and abrasion by stone, coal, sand, etc.
- The deposit can be machined by grinding and gouging.

Recommendations:

- Keep a short arc.
- Preheating of low-alloy steels is not necessary.
- Large, heavy materials with high tensile strength, heat to 250-300°C.
- If more than 3 layers are required, build up with DURWELD 300 or softer.
- For higher manganese content steels, high carbon steels and hardenability enhancing ingredients, use INOX B307 buffer.

Base material



Steel

Cast steels

Typical chemical composition %

C	Cr
0,50	5,00

Typical mechanical properties

Hardness	57 - 62 HRC / 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 or 300°C / 2 h

Welding parameters and packing

∅	Length [mm]	Welding current [A]	Weight of packet [kg]	Weight of carton [kg]	Pcs/1 kg
3,2	350 /	100-135	4,5	13,5	27
4,0	450 /	140-180	5,8	17,4	14
5,0	450 /	180-230	5,5	16,5	9