

ABRAWELD 58

Electrodes MMA [SMAW]

Hardfacing and repairing

CLASSIFICATION:	APPROVALS:	APPLICATION:
EN ISO 14700-A : E Fe14 gpc DIN 8555 : E 10-UM-60-GRP	UDT	Hardfacing and repairing Agriculture

- Hardfacing electrode. The deposit is resistant to extreme abrasion and medium impact.
- Recommended for earthmoving and crushing equipment, conveyor screws, bucket teeth and lips and soft ore crushers.
- Weld material can be grinded.
- It is recommended to use buffer layer with INOX B307 or Durweld 17Mn13Cr.

Application

Hardfacing of earthmoving and crushing equipment, ore crushers, augers, bucket teeth and sides, etc.

Base material

Steels
Austenitic-manganese steels
Cast steels

Typical chemical composition %

C	Cr
3,2	32,0

Typical mechanical properties

Hardness	58 HRC (20°C) / The hardness of the deposit depends on the chemical composition of base materials and relevant welding conditions. /
Coating type	rutile
Wear coefficient	2%
Heat treatment	Preheating is not required. For materials with a high carbon content and components that increase hardenability, it is recommended to use a buffer layer, e.g. made of INOX 307
Weld metal recovery	180%
Welding current	
Welding positions	
Redrying	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 /	65-95	4,5	13,5	30
3,2	350 /	110-140	4,0	12,0	17
4,0	450 /	160-200	5,0	15,0	9
5,0	450 /	210-270	5,0	15,0	6