

ABRAWELD 64

Electrodes MMA [SMAW]

Hardfacing and repairing

CLASSIFICATION:	APPROVALS:	APPLICATION:
EN ISO 14700-A : E Fe15 g DIN 8555 : E 10-UM-65-GR	UDT	Hardfacing and repairing

- Hardfacing electrode. The deposit is resistant to extreme abrasion and medium impact up to 450°C.
- Recommended for brick and cement industry, mill blades and scratches, excavator cogs, etc.
- Weld material can be grinded.
- It is recommended to use buffer layer with INOX B307 or Durweld 17Mn13Cr.

Application

Hardfacing of elements in the cement and construction industry (production of bricks, hollow bricks), screws of presses for refractory (ceramic) materials, guide rails of conveyor belts, screws, blades and scrapers of mills, bucket teeth, etc.

Base material



Steel

Cast steels

Typical chemical composition %

C	Cr	Nb
7,0	22,0	7,0

Typical mechanical properties

Hardness	64 HRC (20°C) / The hardness of the deposit depends on the chemical composition of base material and relevant welding conditions. /
Coating type	basic
Wear coefficient	0,5%
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	190%
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
3,2	350 /	140-170	4,0	12,0	17
4,0	450 /	160-200	5,0	15,0	13
5,0	450 /	210-270	5,0	15,0	6