

Classifications

DIN 8555	EN 14700
E 1-UM-350	E Fe 1

Characteristics and field of use

- Good abrasion resistance and multi-layer build up ability.
- Particularly suited for wear resistant surfacing on Mn-Cr-V alloyed parts, such as frogs, track rollers, chain support rolls, sprocket wheels, guide rolls etc.
- Weld metal is machinable with tungsten carbide tools.

Hardness of the pure weld deposit 380 HB
1 layer on steel with C = 0.5 % 420 HB

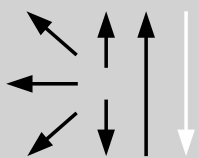
Typical analysis of all weld metal (Wt.-%)

C	Si	Mn	Cr	Fe
0.16	1.10	1.40	1.90	Balance

Welding instruction

Hold stick electrode as vertically as possible. Preheating heavy parts and higher tensile steels to 250-300°C. Re-dry electrode before use at 300°C at 2 h.

Welding positions



Current type DC (+) / AC

Approvals

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Size, Packing and Recommended welding parameters

Size mm	Kg / Pack	Kg / Box	Amperage (A)
3.25 X 350	5.0	20.0	100 – 140
4.00 x 450	6.2	24.8	140 – 180
5.00 X 450	6.2	24.8	190 - 230