



Standards: DIN 8555 E 6 - UM - 55 - GP

Application / Properties: Rutile-covered electrode for depositing hardfacing overlays on components subject by metal to metal. The weld metal is resistant to impact and high compressive stresses. Weldable by AC (OCV 70V) and DC+ in the flat and vertical up position.

Weld metal analysis in % (typical values):

C	Mn	Si	Cr
0.50	0.60	1.90	9.50

Mechanical Properties of all -weld metal :

(single values are typical values)

Hardness as -welding

54 HRC



Welding Parameters

Diameter (mm)	2.5	3.25	4.0
Length (mm)	350	450	450
Amperage(A)	65 - 95	90 - 140	125 - 190



Materials:

Crusher hammers, gear wheels, bucket wheels, bucket teeth and lips, mixers, dredge part, moulds repairing.

Rebaking: required at 300°C 2hrs.