

## ABRAWELD 63

Electrodes MMA [SMAW]

Hardfacing and repairing

<b>CLASSIFICATION:</b>  EN ISO 14700-A : E Fe15 gtc DIN 8555 : E 10-UM-65-GTR AWS A-5.13 : E FeCr-A1	<b>APPROVALS:</b>	<b>APPLICATION:</b>  Hardfacing and repairing
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- Thick coated, high-efficiency (170% yield), hardfacing electrode.
- Recommended for hardfacing components exposed to severe mineral wear including medium impact and pressure as well as moisture.
- The overlay is almost free of slag.

### Application

Pumps, mixer arms, screw conveyors, etc.

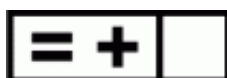
### Typical chemical composition %

<b>C</b>	<b>Si</b>	<b>Cr</b>	<b>Inne</b>
5,0	1,0	34,0	2,0

### Typical mechanical properties

**Hardness** app. 63 HRC /

**Welding current**



**Welding positions**



### Welding parameters and packing

∅	Length [mm]	Welding current [A]
3,2	350 /	100-130
4,0	450 /	140-180
5,0	450 /	180-230

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