

ABRAWELD ULTRA 63

Electrodes MMA [SMAW]

Hardfacing and repairing

CLASSIFICATION:	APPROVALS:	APPLICATION:
EN ISO 14700-A : E Fe14 DIN 8555 : E 10-UM-60-GTR AWS A-5.13 : E FeCr-A1		Hardfacing and repairing

- Tubular electrode filled with chromium carbides, recommended for surfacing of parts exposed mainly to abrasion, but also to impact.
- High content of chromium carbides in the austenitic matrix.
- Due to the special metallurgical structure, the electrode can be used with low current.
- High hardness achieved already in the first layer.
- Deposit weld almost free of slag.


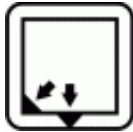
Application

Hardfacing of pump bodies, mixer blades, conveyors, agricultural equipment used in the cement industry, agitator arms, concrete pumps, screw conveyors and cook oven chutes.

Typical chemical composition %

C	Mn	Cr	Inne
5,5	1,5	40,0	2,0

Typical mechanical properties

Hardness	60 HRC (first layer) / 63 HRC (second layer) /
Welding current	 $U_0 < 50V$
Welding positions	
Redrying	150°C / 1 h

Welding parameters and packing

∅	Length [mm]	Welding current [A]	Weight of packet [kg]
6,0	457 /	80-110	5,0
8,0	457 /	120-140	5,0
11,0	457 /	140-180	5,0

METALWELD-FIPROM POLSKA spółka z o.o.

ul. Mikołajczyka 57, 41-200 Sosnowiec

+48 (32) 297 75 50 - 51

+48 (32) 297 75 88

export@metalweld.pl