

TOOLWELD 520

Electrodes MMA [SMAW]

Hardfacing and repairing

CLASSIFICATION: EN ISO 14700-A : E Z Fe3 DIN 8555 : E3-UM-50-CRTZ	APPROVALS:	APPLICATION: Hardfacing and repairing
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- Electrode for surfacing and repairing of tools working on dies and blanking dies, working in cold and hot conditions.
- The deposit is resistant to metal-to-metal wear, corrosion and thermal shocks.
- The deposit is also resistant to adhesion when working at high temperatures.
- Working temperature up to 650°C.

Recommendations:

- Pre-heating to approx. 300°C is recommended before surfacing.
- Interpass temperature should be monitored during surfacing.

Application

Hardfacing of dies, tools working hot and at high temperatures, hardfacing of rolls, molds and dies exposed to high temperatures and thermal shocks.

Typical chemical composition %

C	Si	Mn	Cr	Mo	Fe	Co
0,15	0,60	0,60	14,00	2,30	base	13,00

Typical mechanical properties

Hardness 50 HRC after hardfacing / 53-55 HRC after crushing /

Welding parameters and packing

∅	Length [mm]	Welding current [A]	Weight of packet [kg]	Weight of carton [kg]
3,2	350 /	90-120	5,0	20,0
4,0	450 /	110-150	5,0	20,0

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