

ABRAWELD 54

Electrodes MMA [SMAW]

Hardfacing and repairing

CLASSIFICATION:	APPROVALS:	APPLICATION:
EN ISO 14700-A : E Fe8 gp DIN 8555 : E 6-UM-55-GP	UDT	Hardfacing and repairing

- Hardfacing electrode. Dedicated when abrasion, heavy impact and resistance to metal - metal wear is needed.
- Recommended for mixers, crusher hammers, cams, gears, ploughshares.
- The deposit is difficult to machine.

Application

Hardfacing of crusher hammers, shovel blades, excavator parts, gears, plow blades, camshafts, etc.



Base material

Steels
Austenitic-manganese steels
Cast steels

Typical chemical composition %

C	Si	Cr
0,50	2,0	9,5

Typical mechanical properties

Hardness	54 HRC (20°C) / 300 HB (500°C) / The hardness of the deposit depends on the chemical composition of base material and relevant welding conditions. /
Coating type	rutile-basic
Wear coefficient	2%
Heat treatment	Preheating is not required. For materials with a high carbon content and components that increase hardenability, it is recommended to use a buffer layer, e.g. made of INOX 307
Weld metal recovery	180%
Welding current	
Welding positions	
Redrying	300°C / 2 h
Additional description	Interpass temperature: approx. 200°C

Welding parameters and packing

Ø	Length [mm]	Welding current [A]	Weight of packet [kg]	Weight of carton [kg]	Pcs/1 kg
3,2	350 /	80-150	4,0	12,0	24
4,0	450 /	125-190	5,0	15,0	12

5,0

450 /

180-255

5,0

15,0

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