

# ABRAWELD 58

Electrodes MMA [SMAW]

Hardfacing and repairing

<b>CLASSIFICATION:</b>	<b>APPROVALS:</b>	<b>APPLICATION:</b>
EN ISO 14700-A : E Fe14 gpc DIN 8555 : E 10-UM-60-GRP	UDT	Hardfacing and repairing Agriculture

- Hardfacing electrode. The deposit is resistant to extreme abrasion and medium impact.
- Recommended for earthmoving and crushing equipment, conveyor screws, bucket teeth and lips and soft ore crushers.
- Weld material can be grinded.
- It is recommended to use buffer layer with INOX B307 or Durweld 17Mn13Cr.

### Application

Hardfacing of earthmoving and crushing equipment, ore crushers, augers, bucket teeth and sides, etc.

### Base material

Steels  
Austenitic-manganese steels  
Cast steels

### Typical chemical composition %

<b>C</b>	<b>Cr</b>
3,2	32,0

### Typical mechanical properties

<b>Hardness</b>	58 HRC (20°C) / The hardness of the deposit depends on the chemical composition of base materials and relevant welding conditions. /
<b>Coating type</b>	rutile
<b>Wear coefficient</b>	2%
<b>Heat treatment</b>	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
<b>Weld metal recovery</b>	180%
<b>Welding current</b>	
<b>Welding positions</b>	
<b>Redrying</b>	300°C / 2 h

### Welding parameters and packing

∅	Length [mm]	Welding current [A]	Weight of packet [kg]	Weight of carton [kg]	Pcs/1 kg
3,2	350 /	110-140	4,0	12,0	17
4,0	450 /	160-200	5,0	15,0	9
5,0	450 /	210-270	5,0	15,0	6

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