

DURWELD 14Mn

Electrodes MMA [SMAW]

Hardfacing and repairing

CLASSIFICATION: EN ISO 14700-A : E Fe9 DIN 8555 : E 7-UM-200-KP	APPROVALS:	APPLICATION: Hardfacing and repairing
--	-------------------	---

- Basic electrode for joining and hardfacing of parts which are subject to heavy impact and abrasion, resistant to metal-to-metal friction.
- The deposit can be hardened which increases the resistance for abrasion.
- The deposit can be machined before curing.
- This product is not suitable for non austenitic steels.

Application

Hardfacing of heavy elements of crushers, such as jaws, cones, covers and armors of rotary crushers and railway rails made of 14Mn steel.



Base material

Austenitic 14% Mn steels

Typical chemical composition %

C	Mn	Mo
1,20	12,50	0,70

Typical mechanical properties

Hardness	220 HB (after hardfacing) / 48 HRC (after hardening) / The hardness of the overlay depends on the relevant welding conditions, the number of layers and the chemical composition of the base material. /
Coating type	basic
Wear coefficient	75%
Weld metal recovery	110%
Welding current	
Welding positions	
Redrying	300°C / 2h

Welding parameters and packing

∅	Length [mm]	Welding current [A]	Weight of packet [kg]	Weight of carton [kg]	Pcs/1 kg
3,2	450 /	110-135	4,0	12,0	21
4,0	450 /	140-175	5,0	15,0	13
5,0	450 /	180-230	5,0	15,0	9

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