

## DURWELD 14Mn4Cr

Electrodes MMA [SMAW]

Hardfacing and repairing

<b>CLASSIFICATION:</b>	<b>APPROVALS:</b>	<b>APPLICATION:</b>
DIN 8555 : ~ E 7-UM-200-KPG		Hardfacing and repairing

- Electrode for joining and hardfacing of the parts which are subject to heavy impact and abrasion.
- The deposit can be hardened which increases the resistance for abrasion.
- The deposit can be mechanically shaped before hardening.
- After hardening, greater abrasion resistance is obtained.

### Application

Hardfacing of heavy crusher components such as crushing roll teeth, crusher gears, twin roll crusher teeth, excavator buckets, railway rails (if Mn steel).



### Base material

Austenitic 14% Mn steels  
 Low alloyed steels  
 All difficult to weld steels (using appropriate technology)

### Typical chemical composition %

<b>C</b>	<b>Mn</b>	<b>Cr</b>	<b>Ni</b>	<b>Mo</b>
0,90	13,5	3,70	3,50	0,70

### Typical mechanical properties

<b>Hardness</b>	220 HB (afret hardfacing) / 50 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. /
<b>Coating type</b>	basic
<b>Wear coefficient</b>	75%
<b>Weld metal recovery</b>	120%
<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	450 /	100-140	4,5	13,5	19
4,0	450 /	140-180	4,5	13,5	13
5,0	450 /	180-230	4,5	13,5	8

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