

DURWELD 17Mn13Cr

Electrodes MMA [SMAW]

Hardfacing and repairing

CLASSIFICATION:	APPROVALS:	APPLICATION:
DIN 8555 : E 7-UM-250-KPG		Hardfacing and repairing

- Electrode for joining and hardfacing of parts which are subject to heavy impact and cavitation up to 500°C.
- Can be used as the buffer layer for ABRAWELD electrodes.
- Recommended as a base for hardfacing of hard overlays.
- The overlay can be machined before curing.

Application

Hardfacing of rails, buckets, pistons of hydraulic pumps and elements of crushers exposed to high impact.

Base material

Austenitic 14% Mn steels
 Low alloyed steels
 All difficult to weld steels

Typical chemical composition %

C	Mn	Cr
0,60	16,50	13,50

Typical mechanical properties

Hardness	220 HB (after hardfacing) / 48 HRC (after hardening) / The hardness of the deposit depends on the chemical composition of base material and relevant welding conditions. /
Coating type	rutile
Wear coefficient	70%
Weld metal recovery	140%
Welding current	
Welding positions	
Redrying	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	5,4	16,2	15
4,0	450 /	150-190	5,4	16,2	10
5,0	450 /	200-250	5,4	16,2	7

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