

DURWELD 250

Electrodes MMA [SMAW]

Hardfacing and repairing

CLASSIFICATION:	APPROVALS:	APPLICATION:
EN ISO 14700-A : E Fe1 DIN 8555 : E 1-UM-250 P	UDT	Hardfacing and repairing

- Basic hardfacing electrode with the addition of Cr for surfacing workpieces where medium hardness is required.
- Excellent slag release, low spatter.
- The joint is covered with an uniform, very fine scale.
- Overlay resistant to abrasion and high impact.
- The overlay is not susceptible to hardening.

Application

Hardfacing of hot working tools, such as: forging dies, shear knives, punches, sections, hammers, etc. Buffer material for harder overlays.



Base material

Steel
Cast steels

Typical chemical composition %

C	Mn	Cr
0,16	1,00	1,20

Typical mechanical properties

Hardness	220 - 270 HB / 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
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
2,5	350 /	70-90	4,5	13,5	54
3,2	350 /	100-135	4,5	13,5	28
4,0	450 /	130-170	5,5	16,5	13
5,0	450 /	180-220	5,5	16,5	9

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