

ABRAWELD 69

Electrodes MMA [SMAW]

Hardfacing and repairing

CLASSIFICATION:	APPROVALS:	APPLICATION:
EN ISO 14700-A : E Fe15 DIN 8555 : E 10-UM-65-GTRZ AWS A-5.13 : E FeCr-A1		Hardfacing and repairing

- Thick coated, high-efficiency (210%), hardfacing electrode.
- Recommended for hardfacing components subjected to very heavy mineral wear, also combined to higher working temperature.
- The overlay is almost free of slag.

Application

Mixer arms, screw conveyors, sintering plants, coke oven plants, steel mills, coal and ore mining

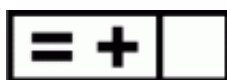
Typical chemical composition %

C	Si	Cr	Inne
4,0	2,0	28,0	4,0

Typical mechanical properties

Hardness 67 - 69 HRC /

Welding current



Welding positions



Welding parameters and packing

Ø	Length [mm]	Welding current [A]	Weight of packet [kg]
3,2	350 /	100-130	5,0
4,0	450 /	140-180	6,0
5,0	450 /	180-230	6,0

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