

DURWELD 600V

Electrodes MMA [SMAW]

Hardfacing and repairing

CLASSIFICATION:	APPROVALS:	APPLICATION:
EN ISO 14700-A : E Fe8 DIN 8555 : E 6-UM-60		Hardfacing and repairing Mining

- The hardfacing electrode, Cr-Mo-V alloyed, producing tough and wear resistant deposits, abrasion and impact resistant.
- The deposit is crack free, smooth and the slag is self removable.
- Recommended for the building and mining industry.

Typical chemical composition %

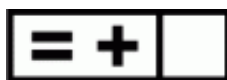
C	Mn	Cr	Mo	V
0,50	0,80	7,50	0,50	0,50

Typical mechanical properties

Hardness 57 - 62 HRC / The hardness of the deposit depends on the chemical composition of base material and relevant welding conditions. /

Coating type Basic

Welding current



Welding positions



Redrying 400°C / 1 h or 300°C / 2 h

Welding parameters and packing

Ø	Length [mm]	Welding current [A]	Weight of packet [kg]	Weight of carton [kg]
3,2	350 /	100 - 135	4,5	18,0
4,0	450 /	140 - 180	5,5	22,0
5,0	450 /	180 - 230	5,5	22,0

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