



ABRAWELD 66

Electrodes MMA [SMAW]

Hardfacing and repairing

CLASSIFICATION:		APPROVALS:		APPLICATION:	
EN ISO 14700-A : E Fe16 gtc DIN 8555 : E 10-UM-65-GRZ		UDT		Hardfacing and repairing	
<ul style="list-style-type: none">• Hardfacing electrode. The deposit is resistant to extreme abrasion and medium impact up to 600°C.• Recommended for brick and cement industry, earthmoving equipment and fire grate teeth in iron and steel industry.• Weld material can be grinded.• It is recommended to use buffer layer with INOX B307 or Durweld 17MnCr13.					
Recommendations: <ul style="list-style-type: none">• Keep the arc short.• Multi-pass overlays require a primer.					
Application					
Hardfacing of earthmoving equipment, wearing parts in the cement and construction industries, furnace grate rods, furnace grate teeth in the foundry and steel industry.					
Base material					
Steel					
Cast steels					
Typical chemical composition %					
C	Cr	Mo	V	Nb	W
6,0	22,0	6,0	1,0	6,0	2,0
Typical mechanical properties					
Hardness		66 HRC (20°C) / 50 HRC (600°C) / The hardness of the deposit depends on the chemical composition of base material and relevant welding conditions. /			
Coating type		basic			
Heat treatment		Preheating is not required			
Weld metal recovery		235%			
Welding current					
Welding positions					
Redrying		300°C / 2 h			
Welding parameters and packing					
Ø	Length [mm]	Welding current [A]	Weight of packet [kg]	Weight of carton [kg]	Pcs/1 kg
3,2	350 /	100-130	4,0	12,0	15

4,0	450 /	160-190	5,5	16,5	8
5,0	450 /	220-250	5,5	16,5	5

METALWELD-FIPROM POLSKA spółka z o.o.

ul. Mikołajczyka 57, 41-200 Sosnowiec

+48 (32) 297 75 50 - 51

+48 (32) 297 75 88

export@metalweld.pl