

ABRAWELD ULTRA WSC Fe

Electrodes MMA [SMAW]

Hardfacing and repairing

CLASSIFICATION:	APPROVALS:	APPLICATION:
EN ISO 14700-A : E Fe20 gp DIN 8555 : E 21-GF-60-GP		Hardfacing and repairing

- Steel tube filled with fused tungsten carbides. The hardness of the fused tungsten carbides it's 2300 HV.
- This product is recommended for hardfacing when resistance for high abrasion, especially mineral is needed: mining, drilling, special civil engineering, etc.

Recommendations

- It is not recommended to hardface base materials with a carbon content above 0.45%.
- To obtain the best results, hardfacing surfaces should be cleaned of rust, grease and other dirt.
- The lowest possible curency should be used in order to avoid the melting of the hard particles.
- It is possible to supply the electrode with different grain sizes depending on the application.



Application

Hardfacing of earthmoving equipment, wearing parts in the cement and construction industries.
Hearth grate rods, grate in foundry and steel industries.
Sheathing and armouring in the mining industry.
Road construction, well drilling.

Typical chemical composition %

Fe	Inne
app. 40%	WSC app. 60%

Typical mechanical properties

Hardness	Hardness of fused tungsten carbide: >2300 HV /
Welding current	 $U_0 < 50V$
Welding positions	

Welding parameters and packing

Ø	Length [mm]	Welding current [A]	Weight of packet [kg]	Weight of carton [kg]
3,5	350 /	70-90	5,0	20,0
4,5	350 /	80-100	5,0	20,0
5,0	350 /	100-120	5,0	20,0
6,0	350 /	120-160	5,0	20,0

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