

ABRAWELD ULTRA 60

Electrodes MMA [SMAW]

Hardfacing and repairing

CLASSIFICATION:	APPROVALS:	APPLICATION:
EN ISO 14700-A : E Fe16 gc DIN 8555 : E 10 UM-60-GR		Hardfacing and repairing

- Tubular hardfacing electrode with chromium carbides.
- Recommended when abrasion and impact resistance is needed.
- Can be welded with very low currency.
- High hardness already in the first layer.
- It is recommended to use the bufer layer of INOX B307 on old surfaces.

Application

Hardfacing of pump bodies, mixer blades and arms, concrete pumps, coke oven valves, screw conveyors, in agricultural machinery, cement and metallurgical industries.



Base material

Non-alloy and alloy steels			
Non-alloy and alloy castings			

Typical chemical composition %

C	Mn	Cr	Fe	Inne
4,0	4,0	27,0	rest	microall oying el ements 6,0

Typical mechanical properties

Hardness	First layer: 60 HRC / Third layer: 58 HRC /
Welding current	 $U_0 < 50V$
Welding positions	
Redrying	150 (+/-10)°C / 1 h

Welding parameters and packing

Ø	Length [mm]	Welding current [A]	Weight of packet [kg]	Weight of carton [kg]
6,0	457 /	80-110	5,0	20,0
8,0	457 /	120-140	5,0	20,0
11,0	457 /	140-180	5,0	20,0

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