

# ABRAWELD ULTRA 60

Electrodes MMA [SMAW]

Hardfacing and repairing

<b>CLASSIFICATION:</b>	<b>APPROVALS:</b>	<b>APPLICATION:</b>
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 %

<b>C</b>	<b>Mn</b>	<b>Cr</b>	<b>Fe</b>	<b>Inne</b>
4,0	4,0	27,0	rest	microall oying el ements 6,0

## Typical mechanical properties

<b>Hardness</b>	First layer: 60 HRC / Third layer: 58 HRC /
<b>Welding current</b>	 <b>U<sub>0</sub> &lt; 50 V</b>
<b>Welding positions</b>	
<b>Redrying</b>	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

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