

HARDFACE 48-E

CLASSIFICATION

DIN 8555 : E3-UM-50-PT

EN 14700 : E Fe3

DESCRIPTION AND APPLICATIONS

- Basic electrode giving a martensitic weld deposit
- Very high resistance to metal to metal wear up to 550°C, to pressure and to impacts
- Particularly well adapted to hardfacing tool steels type X38CrMo5.1
- Applications : hot shearing, hot press tooling, extrusion pistons, dies
- Complements Welding Alloys cored wire HARDFACE R46-G

Base materials: High strength carbon steels and hot working steels

Material no.	DIN classification	Material no.	DIN classification
1.2311	40CrMnMo 7	1.2367	X38CrMoV 5 3
1.2343	X38CrMoV 5 1	1.2606	X37CrMoW 5 1
1.2344	X40CrMoV 5 1	1.2713	55NiCrMoV 6
1.2365	X32CrMoV 3 3	1.2714	56NiCrMoV 7

TYPICAL ALL-WELD METAL ANALYSIS

C	Si	Mn	Cr	Mo	Fe
0.30	0.50	0.60	5.50	4.10	Balance

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness – as welded

~ 48 HRc

OPERATING CONDITIONS

Electrode ØxL [mm]	2.5x300	3.2x350	4.0x450
Current [A]	60-90	80-110	100-130

Preheat the workpiece to 250-400°C depending on thickness and alloy. Hold the electrode vertically with a short arc. Keep temperature during welding and let the workpiece cool slowly.

Subsequent machining is possible by grinding or with tungsten carbide tools.

= + ~ 70 V

WELDING POSITIONS			
1G/PA, 2F/PB, 2G/PC, 3G/PF, 4G/PE			
PACKAGING			
Electrode ØxL [mm]	2.5x300	3.2x350	4.0x450
Weight/box [kg]	4	5	6.5
Piece/box	~ 214	~ 139	~ 92