HARDFACE AP-E

CLASSIFICATION

DIN 8555 : E7-UM-250-KPR

EN 14700 : E Fe9

DESCRIPTION AND APPLICATIONS

- High recovery (140%), basic electrode
- High rate of work-hardening – Non magnetic deposit strongly resistant to impact and high pressures
- Rebuilding, buffer layers and assembly of manganese steels. Buffer layer before hardfacing with chromium cast irons
- Applications: repair work on railway frogs and crossings. Hammers, bars, cones and jaws for crushers
- Complements Welding Alloys cored wire HARDFACE AP

TYPICAL ALL-WELD METAL ANALYSIS

C	Si	Mn	Cr	Fe
0.60	0.30	16.0	14.0	Balance

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness – as welded	Hardness after work hardening
~ 240 HB	48 HRC

OPERATING CONDITIONS

Electrode ØxL [mm]	2.5x350	3.2x350	4.0x450
Current [A]	90	130	160

Redrying, if necessary, 1h/300°C. Weld with a minimum heat input (low current, short beads) in order to respect an interpass temperature of 250°C maximum. Do not preheat the piece to weld!

= + ~ 70V

WELDING POSITIONS

1G/PA, 2F/PB, 2G/PC

PACKAGING			
Electrode ØxL [mm]	2.5x350	3.2x350	4.0x450
Weight/box [kg]	4.5	5	6.5
Piece/box	~ 176	~ 122	~ 77