

HARDFACE AR-E

CLASSIFICATION

DIN 8555 : E4-UM-60-ST

EN 14700 : E Fe4

DESCRIPTION AND APPLICATIONS

- Rutile- basic electrode for hardfacing of cutting tools
- Martensitic weld deposit with C-Cr-Mo-V-W
- Applications: repair work on blades, machining tools, cold working punches and dies
- Complements Welding Alloys cored wire HARDFACE AR-G

TYPICAL ALL-WELD METAL ANALYSIS

C	Si	Mn	Cr	Mo	V	W	Fe
0.80	0.50	0.50	5.0	10.0	1.5	1.5	Balance

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness – as welded

~ 65 HRc

OPERATING CONDITIONS

Electrode ØxL [mm]	2.5x350	3.2x350	4.0x450
Current [A]	80	110	150

Redrying, if necessary, 1h/250°C. Pre-heat according to base material and application. Slow cooling down.

= + ~ 50 V

WELDING POSITIONS

1G/PA, 2F/PB, 2G/PC, 3G/PF, 4G/PE

PACKAGING

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