HARDFACE CN-E

CLASSIFICATION

EN 14700 : E Fe15

DIN 8555* : E10-UM-65-GR

*Former classification replaced by EN 14700

DESCRIPTION

- High recovery basic electrode with pleasing arc characteristics and a slag-free deposit
- High chromium cast iron with niobium and chromium carbides
- Very good wear resistance to fine abrasive particles of high hardness
- Maintains its abrasion resistance up to 450°C
- Very high recovery rate: 190%

APPLICATIONS

Hardface CN-E is designed for surfacing parts subjected to heavy abrasion with moderate impact

Examples

Riddling, blast furnace hoppers, extractor fans, cement presses, mixer blades, brick presses etc.

TYPICAL ALL-WELD METAL ANALYSIS

C	Si	Cr	Nb
5.0	1.5	24	7

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness 3-layers deposit on mild steel: ~64 HRc

OPERATING CONDITIONS

Electrode ØxL [mm]	3.2x350	4.0x450	5.0x450
Current [A]	130-150	140-190	190-250

Redrying, if necessary, 2h/300°C. Guide electrode almost vertically with a short arc and a slight weave. Keep the welding current low to minimize dilution from the base material.

= + 50 V

WELDING POSITIONS			
1G/PA			
PACKAGING			
Electrode ØxL [mm]	3.2x350	4.0x450	5.0x450
Weight/box [kg]	4.5	6.0	6.0
Piece/box	71	48	30