HARDFACE DCO-E

CLASSIFICATION

DIN 8555 : E3-UM-50-CRTZ

EN 14700 : ~E Fe3

DESCRIPTION AND APPLICATIONS

- Rutile-basic electrode
- Superalloy offering similar performance to cobalt based alloys
- High cracking resistance little affected by dilution, highly resistant to thermal shock, may be polished and keeps its properties to 550°C
- Applications: traction rollers in continuous casting installations, valves for diesel engines, steam valves, deburring stamps and dies, moulds for ceramic tiles, screws for filled plastic
- Complements Welding Alloys cored wire HARDFACE DCO

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	Co	Fe
0.15	0.60	0.60	14.0	2.30	13.0	Balance

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness – as welded	After work hardening
47 HRc	55 HRc

OPERATING CONDITIONS

Electrode ØxL [mm]	2.5x300	3.2x350	4.0x450

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Current [A]	60-90	90-120	110-150

Re-dry, if necessary, 2h/300°C.Clean weld zone properly. Preheat massive work pieces to 150-400°C, depending on the composition. Hold the electrode vertically with a short arc. Keep temperature during welding and let the work piece cool slowly.

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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	~ 195	~ 125	~ 80