

HARDFACE L-E

CLASSIFICATION

EN 14700 : E Fe6

DIN 8555 : E6-UM-60-S

DESCRIPTION AND APPLICATIONS

- Basic coated general purpose hardfacing electrode for applications subject to impact, compression and abrasive wear.
- For hardfacing on components made of C-steel, cast steel and Manganese steel.
- The deposit is tough-hard and crack resistant.
- Recovery of the electrode approx. 120%.
- Special applications: Hardfacing of block presses, crusher jaws, wheel rims, rollers, caterpillar tracks, ploughshares, running surfaces, cutting edges etc...

TYPICAL ALL-WELD METAL ANALYSIS

C	Si	Mn	Cr
0.5	2.00	0.6	9.5

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness – 3 layer deposit on mild steel

~ 58 HRc

OPERATING CONDITIONS

Electrode ØxL [mm]	2.5x350	3.2x350	4.0x450	5.0x450
Current [A]	60-90	90-120	110-160	170-210

Redrying, if necessary, 2h/300°C. Guide electrode almost vertically with a short arc. On materials sensitive to cracks a buffer-layer with Tetra 307-E is recommended.

= + ~ 70 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]	5.0	5.0	6.5
Piece/box	~ 250	~ 152	~ 96