

RIMCODUR 600

DIN 8555 : E6- UM-60

For Hardfacing

APPLICATIONS & CHARACTERISTICS

RIMCODUR 600 is low hydrogen type basic coated hardfacing stick electrode for hardfacing of cutter knives, dredger and mixer and excavator buckets. The deposited weld metal has martensite structure.

NOTE ON USAGE

- Redry the electrodes at 300 ~ 400°C for 1~2 hrs prior to use.
- Hold the electrode as vertically as possible with a short arc.
- Preheat at 150°C and over in general.
- In the case of multi layer welding, the buffer layer welding should be done by low hydrogen type carbon steel electrode.



WELDING POSITIONS

PA, PB

TYPICAL CHEMICAL COMPOSITION OR ALL WELD METAL (%):

C	Si	Mn	P	S	Ni	Cr	Mo	W
0.48	1.42	1.36	0.015	0.012	0.03	3.65	0.02	0.01

Hardness of the pure weld deposit 60 HRC (668 HV)

ELECTRODE SIZES AND RECOMMENDED CURRENT RANGE POLARITY : AC OR DC +

Dia (mm)	3.2	4.0	5.00
Length (mm)	350	40	400
Amps.	90~130	140~170	190~240

STANDARD PACKAGING :

3.2 mm Dia }
4.0 mm Dia } 5kg / PKT
5.0 mm Dia }



RIMCOFONTE

AWS : A5.15-90 ENiFe-CI
EN ISO 1071:2003 : ECNiFe-CI1
JIS : Z 3252 : DFCNiFe

For Stick Welding of Cast Iron

APPLICATIONS & CHARACTERISTICS

RIMCOFONTE ENiFe-CI is a covered electrode with graphite type coating flux. The weld metal provides low expansion co-efficient, less hardening and good machining property. It is suitable to join Spheroidal graphite cast iron and repairing of cast iron products like Cylinder covers, motor beds, casings and gears.

NOTE ON USAGE

- Clean up the contaminations on the steel.
- Preheat the base metal at 150~300°C
- Keep the arc as short as possible.
- Redry the electrodes at 70 ~ 120°C for 30 ~ 60 minutes.



WELDING POSITIONS

PA, PB

TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt %)

C	Mn	Si	P	S	Ni	Fe	Cu	AL
0.80	0.45	0.38	0.006	0.003	55.5	Bal.	0.05	0.05

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL

TS mpa	Hardness (HV)
550	180~210

ELECTRODE SIZES AND RECOMMENDED CURRENT RANGE POLARITY : AC OR DC +

Dia (mm)	2.6	3.2	4.0
Length (mm)	300	350	350
Amps.	60~80	80~120	120~150

STANDARD PACKAGING :

2.6 mm }
3.2 mm } 5 kg / PKT
4.0 mm }

