SUPRADUR 600

OERLIKON

MMA Electrodes
Hardfacing

Semi-thick basic coated rutile MMA electrode which is easy to use. Weld metal hardness approx. 550-650 HV and can be ground. Can be used for hardfacing carbon steels and low alloy steels. Preheating up to 400 °C is always necessary, especially for large workpieces. Very good resistance to medium impacts. Examples: civil works and mining equipment, shovel teeth, buckets, crawler shoes. Deposit a maximum of 3 layers. A tough buffer layer using Univers or Supradur 400 electrodes is only required in the case of very crack sensitive base metal.

Classification	Approvals	Grades
EN 14700: E Fe2		

Analysis of all-weld metal (Typical values in %)

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	Fe	W	Cu
0.60	1.10	1	-	-	2.80	-	-	-	Rem	-	-

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm^2	Tensile Strength N/mm^2	Elongation A5 (%)	Impact Energy ISO - V (J)	Hardness
As Welded	-	-	-	-	550-650 HV

Storage and redrying

Keep dry and avoid condensation.
Re-drying not generally required.
If necessary: 150-200 °C for 2 hours, 5 times max.

Current condition and welding position

DC-; AC

Packaging data

Diameter (mm)	Length (mm)	Current (A)	Electrode average weight (g)	Weld metal weight per electrode (g)
3,2	450	90-120	40,6	24,4
4,0	450	120-150	61,6	36,9
5,0	450	150-185	97,5	58,5