SUPRADUR 600RB

OERLIKON

MMA Electrodes
Hardfacing

Thick rutile coated MMA electrode for depositing tough and wear resisting hard facing overlays. The weld metal retains sufficient hardness up to +600°C. It is machinable only by grinding. In case of crack sensitive base metals, a tough buffer layer made with Univers or Citochromax N electrodes is required with a further layer after every third hard facing layer. Suitable hard facing applications where resistance at temperatures is a prime concern, as in hot cut offs, dies for pressure castings, rolls, crushers and others.

Classification	
DIN	8555: E 3- UM-60-T
EN	14700: E Fe3

Approvals	Grades
DB	

see Appendix, Classification Society Approvals, for details pag. 521

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

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	Fe	W	Cu
0.50	0.50	0.80	-	-	7	-	0.50	-	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	-	-	-	-	57-62 HRC

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

AC; DC-

Packaging data

Diameter (mm)	Length (mm)	Current (A)	Electrode average weight (g)	Weld metal weight per electrode (g)
2,5	350	60-85	19,2	11,5
3,2	350	100-120	33,4	20,0
4,0	350	140-160	47,9	28,7