

Thick basic coated MMA electrode for depositing tough and wear resisting overlays on structural members subjected to severe wear. The weld metal is free of cracks and pores and resistant to impact and shock. It can be machined only by grinding. Only in case of very crack sensitive base metals, a tough buffer layer, made with UNIVERS or CITOCHROMAX N electrodes, is required. Multi-layer deposits will be free of cracks, even without depositing intermediate buffer layers. Suitable for hard facing excavator parts, bucket edges and bucket teeth, drilling bits, coal planes, conveyor screws, polygon edges, crusher jaws and cones.

Classification	
DIN	8555: E 6 - UM - 60
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	0.30	0.40	-	-	7	-	0.50	-	Rem	-	-

### All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm <sup>2</sup>	Tensile Strength N/mm <sup>2</sup>	Elongation A5 (%)	Impact Energy ISO - V (J)	Hardness
As Welded	-	-	-	-	57-62 HRC

### Storage and redrying

Keep dry and avoid condensation.

Re-drying recommended at 300-350 °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)
2,5	350	70-90	21,6	13,0
3,2	450	100-135	45,2	27,1
4,0	450	140-180	68,3	41,0
5,0	450	190-240	110,7	66,4
6,0	450	230-280	159,4	95,6