

Thick rutile coated MMA electrode depositing a hypereutectic chromium hard deposit. It is suitable for producing highly wear resisting deposits subject to abrasion by mineral particles. The typical transverse cracks appearing in this hard facing weld metal are not detrimental to abrasion resistance. However, the weld metal is not resistant to impact and shock, and is machinable only by grinding. On difficult-to-weld steels, a buffer layer made with Citochromax N electrodes is required. Supradur V1000 produces very smooth weld beads with flat penetration. Metal recovery is approx. 160 %. Suitable for hard facing wearing parts subject to mineral abrasion, such as, conveyor screws, mixer blades, concrete pump parts, slurry pumps, stirring and agitator parts, crusher parts, excavator bucket edges, coal planes subject to corrosion at elevated temperatures.

### Classification

DIN	8555: E 10 - UM - 60 GR
EN	14700: E Fe14

### Approvals

### Grades

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

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	Fe	W	Cu
4,30	1	1	-	-	34	-	-	-	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	-	-	-	-	58-62 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

**AC; DC+**



PA

### Packaging data

Diameter (mm)	Length (mm)	Current (A)	Electrode average weight (g)	Weld metal weight per electrode (g)
3,2	450	120-140	73,0	58,4
4,0	450	170-190	104,2	83,3