

Special MMA electrode with a flux cored wire used as core wire, for hardfacing of steels where a very high resistance against abrasion is required. Applications: hardfacing of pieces in contact with sand, clay and similar materials like drilling tools, mixer blades, parts of earth moving machines. Weld metal is not machinable.

Hardness in as welded condition: 57-62 HRC

### Classification

DIN	8555: E 10 UM 60 RZ
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
3-4	1-1.50	1-1.50	≤ 0.030	≤ 0.030	30-38	-	0.50	-	-	-	-

### 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
PWHT 620°C x 1h	-	-	-	-	640-740 HB

### Storage and redrying

Keep dry and avoid condensation.

Re-drying not generally required.

If necessary: 300-350 °C for 2 hours, 5 times max.

### Current condition and welding position

AC; DC+



PA PB

### Packaging data

Diameter (mm)	Length (mm)	Current (A)	Electrode average weight (g)	Weld metal weight per electrode (g)
3,2	350	90-130	45,0	36,0
4,0	350	125 - 170	68,0	54,4
5,0	350	170 - 220	106,0	84,8