

ABRACITO 62S

MMA Electrodes Hardfacing

Basic-graphite coated MMA electrode with an efficiency of 200%, depositing a special chromium cast iron. As welded hardness is approx. 750HV. Number of layers should be limited to 3. Resistance to severe abrasion at high temperatures (to 650°C). Applications in the iron and steelmaking industry such as mineral crushers, teeth and screens. Production of construction materials and various minerals, quarries, cement plants.

Classification	
EN	14700: E Fe16

Approvals	Grades

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

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	Fe	W	Cu
5	1	1	-	-	24	-	5	6	Rem	2.50	-

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	-	-	-	-	≥ 750 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

AC; DC-



Packaging data

Diameter (mm)	Length (mm)	Current (A)	Electrode average weight (g)	Weld metal weight per electrode (g)
3,2	350	120-140	50,9	30,5
4,0	450	160-190	98,9	59,4