


Technical data sheet <small>011121MBA</small>	Coated SMAW Electrode WA HARDFACE 48-E	 Welding Alloys
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CLASSIFICATION

EN 14700: E Fe3

DESCRIPTION

- Basic coated electrode for hardfacing
- Strong and tough hot working steel type deposit for service temperatures up to 550°C
- Quiet and stable arc, easy slag removal

APPLICATIONS

Hardfacing and repair of parts subjected to severe compression, compression and impact loads at high temperature. Production of new cold and hot working tools by hardfacing on high tensile strength base steel material.

Examples

Press tooling, hot-shear blades, extrusion press pistons, gear teeth, cable drums, anvils, dies, forging tools, trimming tools, punching tools etc.

TYPICAL ALL-WELD METAL ANALYSIS [%]

C	Mn	Si	Cr	Mo	Fe
0.3	0.6	0.5	5.0	4.0	Bal.

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness

As welded all-weld metal:

45-50 HRc

Machinability:

by grinding

OPERATING CONDITIONS

Electrode Ø x L [mm]	3.2 x 350	4.0 x 450	5.0 x 450
Current [A]	60 - 90	80 - 120	100 - 150
= +	~ 70V		

Preheat the workpiece to 200°C - 400°C depending on base metal thickness and type. Hold the electrode vertically and maintain a short arc length. Keep temperature during welding and let the workpiece cool slowly.

WELDING POSITIONS

EN ISO 6947: PA, PB, PC, PF

ASME IX: 1G, 2F, 2G, 3G

PACKAGING

Electrode Ø x L [mm]	3.2 x 350	4.0 x 450	5.0 x 450
Weight/box [kg]	5	6.5	6.5

Other packaging and other sizes: please consult us