


Technical data sheet <small>011121MBA</small>	Coated SMAW Electrode WA HARDFACE 58-E	 Welding Alloys
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CLASSIFICATION

EN 14700: E Fe8

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 moderate 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
0.4	1.0	0.5	7.0	2.5	Bal.

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness:

As welded all-weld metal:

53-58 HRc

Machinability:

by grinding

OPERATING CONDITIONS

Electrode Ø x L [mm]	2.5 x 350	3.2 x 350	4.0 x 450	5.0 x 450
Current [A]	60 - 90	90 - 120	110 - 160	170 - 210
= +	~ 70V			

Recovery: 120 %

Electrodes may be dried at 300°C for two hours, if necessary.

Preheating to 400°C. Hold a short arc. Allow the workpiece to cool down slowly.

WELDING POSITIONS

EN ISO 6947: PA, PC, PF, PE

ASME IX: 1G, 2G, 3G, 4G

PACKAGING

Electrode Ø x L [mm]	2.5 x 350	3.2 x 350	4.0 x 450	5.0 x 450
Weight/box [kg]	5	5	6.5	6.5

Other packaging and other sizes: please consult us

Welding products and techniques evolve constantly. All descriptions, illustrations and properties given in this data sheet are subject to change without notice and can only be considered as suitable for general guidance. This document is intended to help the user make the correct choice of product. It is his responsibility to assess its suitability for his intended application.