


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

EN 14700: EFe3

DESCRIPTION

- Rutile-basic SMAW electrode
- Cr-Co-Mo alloying gives properties comparable to those of cobalt based products
- Suitable for withstanding corrosion and metal-metal wear at temperatures up to 550°C
- Resists cracking and thermal shock
- An economical alternative to cobalt base alloys

APPLICATIONS

- WA HARDFACE DCO-E is used for depositing wear-resistant surfaces on hot-working tools

Examples

Surfacing of hot working stamping punches and dies. Hardfacing continuous casting rollers. Surfacing of diesel and steam valves.

TYPICAL ALL-WELD METAL ANALYSIS [%]

C	Mn	Si	Cr	Mo	Co	Fe
0.15	0.6	0.6	14	2.3	13	Bal.

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness:

as-welded: 47 HRC

Work hardened: 55 HRC

OPERATING CONDITIONS

Electrode Ø x L [mm]	2.5 x 300	3.2 x 350	4.0 x 450
Current [A]	60-90	90-120	110-150
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Re-drying, if necessary, 2h/300°C. Clean weld zone properly. Preheat massive work pieces to 150-400°C, depending on the composition. Hold the electrode vertically with a short arc. Keep temperature during welding and let the work piece cool 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 300	3.2 x 350	4.0 x 450
Weight/box [kg]	4	5	6.5
Piece/box	~ 195	~ 125	~ 80

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.