


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

CLASSIFICATION

EN 14700: E Fe8

DESCRIPTION

- Rutile coated electrode for hardfacing
- Martensitic deposit, highly resistant to impact, abrasion and compressive stresses
- Quiet and stable arc, easy slag removal
- Machinable only by grinding

APPLICATIONS

Hardfacing and repair of parts subjected to the combined action of compression, impact and/or abrasive wear.

Examples

Press tooling, gear teeth, cable drums, dredger buckets, crusher parts, cutting tools, steel mill rolls, conveyor chutes, grizzly bars etc.

TYPICAL ALL-WELD METAL ANALYSIS [%]

C	Mn	Si	Cr	Mo	V	Fe
0.4	1.0	1.0	9.0	1.0	1.0	Bal.

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness as welded: 56 - 60 HRc undiluted

Machinability: by grinding

OPERATING CONDITIONS

Electrode Ø x L [mm]	2.5 x 350	3.2 x 350	4.0 x 450
Current [A]	60 - 90	90 - 120	110 - 160
= +	~ 50V		

Electrodes may be dried at 300°C for two hours, if necessary. Preheating is not required on mild and medium carbon steels. Heavy parts and low alloyed, high carbon tool steels need to be preheated to 250 - 400°C, depending on their composition and thickness. Maintain the temperature during welding. Cool slowly in still air after surfacing. If more than 3 layers are needed, apply softer electrodes for rebuilding.

WELDING POSITIONS

EN ISO 6947: PA, PC

ASME IX: 1G, 2G

PACKAGING

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

Other packaging and other sizes: please consult us