

Электроды для наплавки ELHARD

Технические характеристики

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Hardfacing Electrode ELHARD 250

Standards

TS EN 14700	: E Fe 1
EN 14700	: E Fe 1
DIN 8555	: E1-UM-250

Chemical Composition of Weld Metal % (Typical)

C	Mn	Si	Cr
0.15	1.0	0.8	1.0

Mechanical Properties

Weld Metal Hardness (HB)
240 - 280

Features and Applications

- For tough build-ups on rails, gearwheels, shafts, gear parts, and couplings
- For buffer layers on carbon steels and low-alloyed steels with concurrent extreme compressive stress on anti-wear surfaces
- Re-drying: 300°C / 2h

Resistance Type and Level

Friction ■■■■ □□	High Temp. ■■ □□ □□	Corrosive ■■ □□ □□	Machining ■■■■■■■■
Impact ■■■■■■ □	Thermo Shock ■■ □□ □□	Crack Resistance ■■■■■■■■	

Current Type

D.C.(+)

Operating Data

Product Code	Diameter x Length (mm) / (inch)		Welding Current (A)	Weight g / 100 pcs
3010101744	3.20 x 350	1/8 x 14"	100 - 140	3670
3010101747	4.00 x 450	5/32 x 18"	140 -180	6820
3010101750	5.00 x 450	3/16 x 18"	180- 230	10570

Approvals: SEPRO

Hardfacing Electrode ELHARD 300

Standards

TS EN 14700	: E Fe 1
EN 14700	: E Fe 1
DIN 8555	: E1-UM-300

Chemical Composition of Weld Metal % (Typical)

C	Mn	Si	Cr
0.15	1.3	0.5	1.5

Mechanical Properties

Weld Metal Hardness (HB)
280 - 330

Features and Applications

- Basic coated electrode for medium hardness value
- For tough build-ups, particularly on Mn-Mo-alloyed wing and junction rails with mechanical strength of minimum 880 N/mm²
- Deposit offers ease of machining
- Pre-heating temperature 250°C-350°C.
- Re-drying: 300°C / 2h

Resistance Type and Level

Friction



Impact



High Temp.



Thermo Shock



Corrosive



Crack Resistance



Machining



Current Type

D.C.(+)

Operating Data

Product Code	Diameter x Length (mm) / (inch)		Welding Current (A)	Weight g / 100 pcs
3010101753	3.20 x 350	1/8 x 14"	100 - 140	3571
3010101759	4.00 x 450	5/32 x 18"	140 - 180	6775
3010101762	5.00 x 450	3/16 x 18"	180 - 230	10500

Approvals: SEPRO

Hardfacing Electrode ELHARD 300 R

Standards

TS EN 14700	: E Fe 1
EN 14700	: E Fe 1
DIN 8555	: E1-UM-300

Chemical Composition of Weld Metal % (Typical)

C	Mn	Si	Cr
0.14	0.5	0.5	1.8

Mechanical Properties

Weld Metal Hardness (HB)	Weld Metal Hardness (HB) 900°C/cooled on water/tempered
300 - 330	450 - 470

Features and Applications

- Basic coated electrode for medium hardness value
- For tough build-ups, particularly on Mn-Mo-alloyed wing and junction rails with mechanical strength of minimum 880 N/mm²
- Deposit offers ease of machining
- It can use with alternating current
- Pre-heating temperature 250°C-350°C
- Re-drying: 300°C / 2h

Resistance Type and Level

Friction ■■■■ □□	High Temp. ■■ □□ □□	Corrosive ■■ □□ □□	Machining ■■■■■■■■
Impact ■■■■■■ □	Thermo Shock ■■ □□ □□	Crack Resistance ■■■■■■■■	

Current Type

D.C.(+) / A.C.

Operating Data

Product Code	Diameter x Length (mm) / (inch)		Welding Current (A)	Weight g / 100 pcs
3010101765	3.20 x 350	1/8x 14"	90 - 135	3520
3010101768	4.00 x 450	5/32 x 18"	135 - 180	6690

Approvals: SEPRO

Hardfacing Electrode ELHARD 350

Standards

TS EN 14700	: E Fe 1
EN 14700	: E Fe 1
DIN 8555	: E1-UM-350

Chemical Composition of Weld Metal % (Typical)

C	Mn	Si	Cr
0.17	1.5	0.8	2.0

Mechanical Properties

Weld Metal Hardness (HB)
330 - 380

Features and Applications

- Basic-coated electrode
- Wear resistant surfacing on Mn-Cr-V alloyed frogs, track rollers, idlers, tracks, slideways and drive sprockets
- The deposits are machinable
- Re-drying: 300°C / 2h

Resistance Type and Level

Friction	High Temp.	Corrosive	Machining
■■■■ □□	■■ □□ □□	■■ □□ □□	■■■■■■■■
Impact	Thermo Shock	Crack Resistance	
■■■■■■ □	■■ □□ □□	■■■■■■■■	

Current Type

D.C.(+)

Operating Data

Product Code	Diameter x Length (mm) / (inch)		Welding Current (A)	Weight g / 100 pcs
3010101774	3.20 x 350	1/8 x 14"	100 - 140	3600
3010101777	4.00 x 450	5/32 x 18"	140 - 180	6750
3010101780	5.00 x 450	3/16 x 18"	180 - 230	10540

Approvals: SEPRO

Hardfacing Electrode **ELHARD 400**

Standards

TS EN 14700	: E Fe 1
EN 14700	: E Fe 1
DIN 8555	: E1-UM-400

Chemical Composition of Weld Metal % (Typical)

C	Mn	Si	Cr
0.14	1.5	0.6	2.0

Mechanical Properties

Weld Metal Hardness (HB)
400 - 430

Features and Applications

- Used for dozer, excavator, mineral mining machine equipment like ladle, idler, idler roller and their repair welding
- Re-drying: 300°C / 2h

Resistance Type and Level

Friction	High Temp.	Corrosive	Machining
■■■■ □□	■■ □□ □□	■■ □□ □□	■■■■■■■■
Impact	Thermo Shock	Crack Resistance	
■■■■■■ □	■■ □□ □□	■■■■■■■■	

Current Type

D.C.(+)

Operating Data

Product Code	Diameter x Length (mm) / (inch)		Welding Current (A)	Weight g / 100 pcs
3010101783	4.00 x 450	5/32 x 18"	140-180	6820
3010101786	5.00 x 450	3/16 x 18"	180-230	10900

Approvals: SEPRO

Hardfacing Electrode ELHARD 500

Standards

TS EN 14700	: E Z Fe 1
EN 14700	: E Z Fe 1
DIN 8555	: E1-UM-50

Chemical Composition of Weld Metal % (Typical)

C	Mn	Si	Cr
0.3	1.3	1.2	~5.5

Mechanical Properties

Weld Metal Hardness (HRC)
~50

Features and Applications

- Used in hardfacing applications of guide roller, rope pulleys, ladle lugs etc. for land, mineral and coal sector
- Weld metal has strength against friction and wear
- Pre-heating is generally 200°C according to base material
- Re-drying: 300°C / 2h

Resistance Type and Level

Friction	High Temp.	Corrosive	Machining
■■■■ □□	■■ □□□□	■■ □□□□	■■■■■■■■
Impact	Thermo Shock	Crack Resistance	
■■■■■■ □	■■ □□□□	■■■■■■■■	

Current Type

D.C.(+)

Operating Data

Product Code	Diameter x Length (mm) / (inch)		Welding Current (A)	Weight g / 100 pcs
3010101792	3.20 x 350	1/8 x 14"	100 - 140	3600
3010101798	4.00 x 450	5/32 x 18"	140 - 180	7010
3010101804	5.00 x 450	3/16 x 18"	180 - 230	10900

Approvals: SEPRO

Hardfacing Electrode ELHARD 600

Standards

TS EN 14700	: E Fe 8
EN 14700	: E Fe 8
DIN 8555	: E6-UM-60 P

Chemical Composition of Weld Metal % (Typical)

C	Mn	Si	Mo	V	Cr
0.5	0.5	1.1	1.0	1.0	7.5

Mechanical Properties

Weld Metal Hardness (HRC)	780- 820 °C Cooling in Furnace	Hardening 1000 - 1050°C in Oil	300 - 400°C Tempered
55-59	~ 25 HRC	~60 HRC	53 - 55 HRC

Features and Applications

- Final pass-welding of parts of earth-moving and mining equipment with high resistance to abraision, as well as of parts of hard manganese steels and frags
- Weld metal is resistant to abraision
- Re-drying: 300°C / 2h

Resistance Type and Level

Friction



High Temp.



Corrosive



Machining



Impact



Thermo Shock



Crack Resistance



Current Type

D.C.(+)

Operating Data

Product Code	Diameter x Length (mm) / (inch)		Welding Current (A)	Weight g / 100 pcs
3010101810	3.20 x 350	1/8 x 14"	100 - 140	3660
3010101813	4.00 x 450	5/32 x 18"	140 -180	6820
3010101816	5.00 x 450	5/16 x 18"	180 - 230	10500

Approvals: SEPRO

Hardfacing Electrode ELHARD 600 S

Standards

TS EN 14700	: E Fe 8
EN 14700	: E Fe 8
DIN 8555	: E6-UM-60 P

Chemical Composition of Weld Metal % (Typical)

C	Cr	Si
0.5	9.0	1.8

Mechanical Properties

Weld Metal Hardness (HRC)	Slow Cooling in Furnace	Hardening 1000 - 1050°C in Oil	Tempered 300-400°C
54 - 58	780-820°C	~60 HRC	53 - 55 HRC

Features and Applications

- Applicability in final-layer hardfacing of parts of earth and mineral mining machines, impact drilling and crushing devices, guide springs, edges of cutting tools, hard manganese steels, bucket edges and teeth, all of which are made of alloyed or unalloyed steels, as well as in other materials required to have high resistance to wear
- Electrode of basic type with thick coating
- Inclusion of chromium-silicon alloy, very hard electrode
- Weld metal with ductile and cracking-resistant behaviors: Crack resistance to impact forcing due to its high ductility: Machinability of weld metal through grinding only: Requirement of re-drying at 300°C for 2 hours for moistened electrodes: Recommended pre-heating at 200-300°C for welding thick work pieces and materials tending to get hardened: Requirement of 2-3 layers hardfacing to obtain the highest resistance to wear
- Suitability of harder and/or higher-quality steels to buffer-layering with the GeKa electrodes LASER B 50, TEMPO B 63, or, in some cases, with the GeKa electrodes such as ELOX B307, ELOX R 312
- Re-drying: 300°C / 2h

Resistance Type and Level

Friction	High Temp.	Corrosive	Machining
■■■■■■■■■■	■■■■■■■■■■	■■■■■■■■■■	■■■■■■■■■■
Impact	Thermo Shock	Crack Resistance	
■■■■■■■■■■	■■■■■■■■■■	■■■■■■■■■■	

Current Type

D.C.(+)

Operating Data

Product Code	Diameter x Length (mm) / (inch)		Welding Current (A)	Weight g / 100 pcs
3010101822	3.20 x 350	1/8 x 14"	100 - 140	3650
3010101825	4.00 x 450	5/32 x 18"	140 - 180	6840
3010101828	5.00 x 450	3/16 x 18"	180 - 230	10900

Approvals: SEPRO

Hardfacing Electrode ELHARD 600 R

Standards

TS EN 14700	: E Fe 8
EN 14700	: E Fe 8
DIN 8555	: E6-UM-60 P

Chemical Composition of Weld Metal % (Typical)

C	Mn	Si	Mo	V	Cr
0.5	0.3	1.1	1.0	1.0	7.0

Mechanical Properties

Weld Metal Hardness (HRC)
55 - 59

Features and Applications

- Electrode covering of rutile character
- Usability with a welding transformer (Weldability with AC)
- Weld metal with ductile and cracking-resistant behaviors
- Requirement of re-drying at the temperature range of 300°C-350°C for 2 hours
- Applicability in final layer welding of earth and mineral mining machines. Impact drilling and crushing devices, guide springs, edges of cutting tools, hard manganese steels, bucket edges and teeth

Resistance Type and Level

Friction ■■■■■	High Temp. ■□□□	Corrosive ■■■□□	Machining ■■■□□
Impact ■■■■■	Thermo Shock ■□□□	Crack Resistance ■■■□□	

Current Type

D.C.(+) / A.C.

Operating Data

Product Code	Diameter x Length (mm) / (inch)		Welding Current (A)	Weight g / 100 pcs
3010101831	3.20 x 350	1/8 x 14"	90 - 135	4170
3010101834	4.00 x 450	5/32 x 18"	135 - 180	7640
3010101837	5.00 x 450	3/16 x 18"	180 - 230	11670

Approvals: SEPRO

Hardfacing Electrode ELHARD 650

Standards

TS EN 14700	: E Fe 6
EN 14700	: E Fe 6
DIN 8555	: E6-UM-60

Chemical Composition of Weld Metal % (Typical)

C	Mn	Si	Mo	Nb	Cr
0.55	1.35	0.75	1.2	0.6	6.8

Mechanical Properties

Weld Metal Hardness (HRC)
56 - 59

Features and Applications

- Used in hardfacing applications of earth-moving industry and wearing parts of grinders etc.
- Can be used directly. After three or more passes, buffer-layering must be done according to material grade. (ELHARD 63, ELHARD 250, ELOX R 307 and ELHARD 14 Mn)
- For hardenable steels, preheat temperature is 100-300°C
- Re-drying: 300°C / 2h

Resistance Type and Level

Friction	High Temp.	Corrosive	Machining
■■■■■	■■■■□	■■□□□	■■■□□
Impact	Thermo Shock	Crack Resistance	
■■■■■	■■■■□	■■■■□	

Current Type

D.C.(+)

Operating Data

Product Code	Diameter x Length (mm) / (inch)		Welding Current (A)	Weight g / 100 pcs
3010100333	3.20 x 350	1/8 x 14"	100 - 140	3846
3010101846	4.00 x 450	5/32 x 18"	140 - 180	6930
3010101849	5.00 x 450	3/16 x 18"	180 - 230	10900

Approvals: SEPRO

Hardfacing Electrode ELHARD 650 Si

Standards

TS EN 14700	: E Fe2
EN 14700	: E Fe2
DIN 8555	: E2-UM-60

Chemical Composition of Weld Metal % (Typical)

C	Mn	Si	Cr
0.7	0.5	3.5	3.5

Mechanical Properties

Weld Metal Hardness (HRC)
57 - 62

Features and Applications

- Resistance to abrasion and shocks
- Suitability for uses in hardfacing worn parts of crushing, drilling, excavating, grinding machines in mines/quarries/soil crushing plants
- Weld metal hardness can be exchange between 57 - 62 HRC according to welding current, number of passes, largeness of base metal and chemical composition of base metal

Resistance Type and Level

Friction ■■■■□□	High Temp. ■■□□□□	Corrosive ■■□□□□	Machining ■■■■□□
Impact ■■■■■■□	Thermo Shock ■■□□□□	Crack Resistance ■■■■■■□	

Current Type

D.C.(+)

Operating Data

Product Code	Diameter x Length (mm) / (inch)		Welding Current (A)	Weight g / 100 pcs
3010101855	4.00 x 450	5/32 x 18"	140 - 180	7020
3010101858	5.00 x 450	3/16 x 18"	170 - 210	11200

Approvals: SEPRO

Hardfacing Electrode ELHARD 700

Standards

TS EN 14700	: E Fe 2
EN 14700	: E Fe 2
DIN 8555	: ~E6-UM-60

Chemical Composition of Weld Metal % (Typical)

C	Mn	Si	Mo	V	Cr
0.5	1.5	1.2	0.8	0.8	4.7

Mechanical Properties

Weld Metal Hardness (HRC)
60 - 62

Features and Applications

- Hardfacing of workpieces of steel, cast steel or hard Mn-steel exposed to a combination of impact, compression and abrasive wearing, such as cam shafts, gliding surfaces, gears, plough shares, rails, shunts, crosses, baffle plates, excavator parts, rope carrier wheels etc.
- Weld metal does not cracking
- Re-drying: 300°C-350°C / 2h

Resistance Type and Level

Friction ■■■■ □□	High Temp. ■■ □□ □□	Corrosive ■■ □□ □□	Machining ■■■■ □□
Impact ■■■■ □□	Thermo Shock ■■ □□ □□	Crack Resistance ■■■■ □□	

Current Type

D.C.(+)

Operating Data

Product Code	Diameter x Length (mm) / (inch)		Welding Current (A)	Weight g / 100 pcs
3010101861	3.20 x 350	1/8 x 14"	100 - 150	3920
3010101867	4.00 x 450	5/32 x 18"	140 - 180	7790
3010101870	5.00 x 450	3/16 x 18"	170 - 210	10750

Approvals: SEPRO

Hardfacing Electrode ELHARD 14 Mn

Standards

TS EN 14700	: E Z Fe 9
EN 14700	: E Z Fe 9
DIN 8555	: E 7-UM-200K
AWS A5.13	: E FeMn-A

Chemical Composition of Weld Metal % (Typical)

C	Mn	Si	Ni
0.6	13.5	0.1	3.0

Mechanical Properties

Hardness (HB)	Hardness After Cold Deformation (HB)
180 - 220	~ 550

Features and Applications

- Hardfacing of mining and rock-crushing machine parts as well as of hard manganese steels.
- Machinability of weld metal only if it is not hammered when it is cold, or, if it is not put into operation for a while
- Re-drying at condition 300°C / 2h is required

Resistance Type and Level

Friction ■■■■	High Temp. ■■■■	Corrosive ■■■■	Machining ■■■■
Impact ■■■■	Thermo Shock ■■■■	Crack Resistance ■■■■	

Current Type

D.C.(+)

Operating Data

Product Code	Diameter x Length (mm) / (inch)		Welding Current (A)	Weight g / 100 pcs
3010101876	3.20 x 350	1/8 x 14"	110 - 140	3700
3010101882	4.00 x 450	5/32 x 18"	150 - 180	6870
3010101885	5.00 x 450	3/16 x 18"	180 - 210	10900

Approvals: SEPRO

Hardfacing Electrode ELHARD 40 W

Standards

TS EN 14700	: E Fe 1
EN 14700	: E Fe 1
DIN 8555	: E 3-UM-400-GPTS

Chemical Composition of Weld Metal % (Typical)

C	Mn	Si	Mo	V	Cr	W
0.2	1.1	0.8	0.6	0.4	3.2	0.5

Mechanical Properties

Hardness (HB)
380 - 440

Features and Applications

- Used in surface coating applications and dies made from hot work tool steels.
- According to the base material pre-heat and slow cooling can be done
- Weld metal keep its hardness until 500°C
- Re-drying: 300°C - 350°C / 2h

Resistance Type and Level

Friction ■■■■ □□	High Temp. ■■ □□ □□	Corrosive ■■ □□ □□	Machining ■■■■■■■■
Impact ■■■■■■ □	Thermo Shock ■■ □□ □□	Crack Resistance ■■■■■■■■	

Current Type

D.C.(+)

Operating Data

Product Code	Diameter x Length (mm) / (inch)		Welding Current (A)	Weight g / 100 pcs
3010101906	3.20 x 350	1/8 x 14"	100 - 140	3700
3010101909	4.00 x 350	5/32 x 14"	140 - 180	5390

Approvals: SEPRO

Hardfacing Electrode **ELHARD 58**

Standards

TS EN 14700	: E Fe 4
EN 14700	: E Fe 4
DIN 8555	: ~E 4-UM-60

Chemical Composition of Weld Metal % (Typical)

C	Mn	Si	Mo	Co	V	Cr
0.7	1.0	1.0	7.0	2.0	1.7	4.0

Mechanical Properties

Hardness (HRC)
56 - 60

Features and Applications

- Used in repairing of machining and cutting tools, tool bits, press dies and supports, fillers against strong abraision of excavating and detaching attachments
- Weld deposit has high resistance to friction and wear
- Re-drying: 300°C-350°C / 2h

Resistance Type and Level

Friction ■■■■■□	High Temp. ■■■■■	Corrosive ■■■■□□	Machining ■■■■□□
Impact ■■■■■□	Thermo Shock ■■■■■	Crack Resistance ■■■■■□	

Current Type

D.C.(+) / A.C.

Operating Data

Product Code	Diameter x Length (mm) / (inch)		Welding Current (A)	Weight g / 100 pcs
3010101933	3.20 x 350	1/8 x 14"	80-110	4410
3010101936	4.00 x 350	5/32 x 14"	110-140	5960

Approvals: SEPRO

Hardfacing Electrode ELHARD 60

Standards

TS EN 14700	: E Fe 14
EN 14700	: E Fe 14
DIN 8555	: E 10-UM-60 GRZ

Chemical Composition of Weld Metal % (Typical)

C	Mn	Si	Cr
3.2	0.5	1.0	29.0

Mechanical Properties

Hardness (HRC)
58 - 62

Features and Applications

- On parts primarily exposed to abrasion combined with light impact, such as conveyor screws, mixer blades and mud pumps
- Requirement of re-drying for 2 hours at the temperatures between 300°C and 350°C

Resistance Type and Level

Friction ■■■■■	High Temp. ■■■■□□	Corrosive ■■■■■□	Machining ■■□□□□
Impact ■■■■□□	Thermo Shock ■■□□□□	Crack Resistance ■■□□□□	

Current Type

D.C.(+) / A.C.

Operating Data

Product Code	Diameter x Length (mm) / (inch)		Welding Current (A)	Weight g / 100 pcs
3010101942	3.20 x 350	1/8 x 14"	110 - 140	5080
3010101945	4.00 x 350	5/32 x 14"	170 - 200	7960
3010101948	5.00 x 350	3/16 x 14"	190 - 260	11400

Approvals: SEPRO

Hardfacing Electrode ELHARD 62

Standards

TS EN 14700	: E Fe 16
EN 14700	: E Fe 16
DIN 8555	: ~ E 10-UM-60 GRZ

Chemical Composition of Weld Metal % (Typical)

C	Cr	Nb
6.5	24.0	7.5

Mechanical Properties

Hardness (HRC)
~ 62

Features and Applications

- On parts primarily exposed to abrasion combined with light impact, such as conveyor screws, mixer blades and sand pumps
- Weld metal has resistant to corrosion, friction and impact
- It is not recommended overlap passes
- Requirement of re-drying for minimum 2 hours at temperatures between 300°C and 350°C

Resistance Type and Level

Friction ■■■■	High Temp. ■■■■	Corrosive ■■■■	Machining ■■■■
Impact ■■■■	Thermo Shock ■■■■	Crack Resistance ■■■■	

Current Type

D.C.(+) / A.C.

Operating Data

Product Code	Diameter x Length (mm) / (inch)		Welding Current (A)	Weight g / 100 pcs
3010101951	3.20 x 350	1/8 x 14"	125 - 160	5040
3010101954	4.00 x 350	5/32 x 14"	170 - 200	7710

Approvals: SEPRO

Hardfacing Electrode ELHARD 63

Standards

TS EN 14700	: E Z Fe 14
EN 14700	: E Z Fe 14
DIN 8555	: E 10-UM-60 GRZ
AWS A5.13	: ~E FeCr-A8

Chemical Composition of Weld Metal % (Typical)

C	Cr	Si	Mn
4.5	34.0	1.0	0.5

Mechanical Properties

Hardness (HRC)
60 -64

Features and Applications

- Special coating, high-chromium carbide electrode for hardfacing operations to provide maximum resistance to extreme mineral abrasion
- A typical application is stringer beads on earth-moving, cement mill and brick making equipment
- Weld metal efficiency is ~ % 220.
- Re-drying: 300°C-350°C / min. 2h

Resistance Type and Level

Friction ■■■■	High Temp. ■■■■	Corrosive ■■■■	Machining ■■■■
Impact ■■■■	Thermo Shock ■■■■	Crack Resistance ■■■■	

Current Type

D.C.(+)(-) / A.C.

Operating Data

Product Code	Diameter x Length (mm) / (inch)		Welding Current (A)	Weight g / 100 pcs
3010101960	3.20 x 350	1/8 x 14"	125 - 160	5030
3010101963	4.00 x 350	5/32 Xx 14"	170 - 200	7420
3010101969	5.00 x 350	3/16 x14"	190 - 260	12000

Approvals: SEPRO

Hardfacing Electrode ELHARD 65

Standards

TS EN 14700	: E Fe 16
EN 14700	: E Fe 16
DIN 8555	: E 10-UM-65 GRZ

Chemical Composition of Weld Metal % (Typical)

C	Mn	Si	Mo	V	W	Cr	Nb
4.5	0.3	1.0	5.0	1.7	2.5	23.5	4.0

Mechanical Properties

Hardness (HRC)
63 - 67

Features and Applications

- Super hardfacing electrode with very high content of carbide formers (Mo, V, W, Nb) for deposits subject to extreme sliding mineral abrasion
- Used in blast furnace cover mechanism, breakers, mixers, gimlet, non-steel and cement industry, mining coal industries, weld metal efficiency is ~ % 230
- Re-drying: 300°C-350°C / min. 2h

Resistance Type and Level

Friction ■■■■■	High Temp. ■■■■■	Corrosive ■■■■□□	Machining ■■□□□□
Impact ■■□□□□	Thermo Shock ■■□□□□	Crack Resistance ■■□□□□	

Current Type

D.C.(+) / A.C.

Operating Data

Product Code	Diameter x Length (mm) / (inch)		Welding Current (A)	Weight g / 100 pcs
3010101975	3.20 x 350	1/8 x 14"	110 - 150	5500
3010101978	4.00 x 350	5/32 x 14"	170 - 200	8200
3010101981	5.00 x 350	3/16 x 14"	190 - 250	12500

Approvals: SEPRO

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