Dur CE-Tube WC2

GRUPPE
SMAW Umhüllte Stabelektrode

BESCHREIBUNG
Hardfacing electrode with a tubular core wire containing C-Cr-Co-Zr-Al-WC2 carbides.

ANWENDUNG
This electrode offers a extreme recovery and can be used for overlays with extremely abrasive wear resistance, but with low impact. 3 layers should be considered as maximum.

EIGENSCHAFTEN
Due to the complex carbide combination of Cobalt, Chromium, Aluminium, Zirconium and a extreme high Tungsten content the wear resistance against abrasion is 4 till 8 times better in comparison with C-Cr. alloys. Hard facing knowledge is based on practical experience and years of testing many different procedures and alloys. For your typical application we recommend to consult us for a tailor made welding procedure in order to achieve the best possible results for each job.

1) up to 3 times faster ! (less current with more deposit)
2) No slag losses compare to 40% loss with standard electrodes.!
3) Low amperage offers much lower heat input ! (see point 1)
4) 6 mm is ideal to weld in position and on sharp edges !
5) Moisture resistant coating even in extreme humidity conditions !

NORMBEZEICHNUNGEN
AWS A 5.13: no standard
EN ISO 14700:
DIN 8555: E 21 - GF - 65 - GZ

geeignet für
Sinter plant parts, Swing hammers, Drilling surfaces, Stone crushers, Fan blades, Coke pusher shoes and crushers segments, Shovel, Cement mill parts, Earthmoving equipment, etc.

SCHWEISSPOSITIONEN:

MAIN WELD DEPOSIT COMPOSITION (CARBIDES)

<table>
<thead>
<tr>
<th>WC2</th>
<th>Cr</th>
<th>C</th>
<th>Fe</th>
<th>Co</th>
<th>Al</th>
<th>Mn</th>
<th>Zr</th>
<th>P</th>
</tr>
</thead>
<tbody>
<tr>
<td>+</td>
<td>+</td>
<td>+</td>
<td>+</td>
<td>+</td>
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</tbody>
</table>

MECHANICAL PROPERTIES

<table>
<thead>
<tr>
<th>Nr. Of layers</th>
<th>Rm (N/mm²)</th>
<th>Rp0.2 (N/mm²)</th>
<th>A5 (%)</th>
<th>Impact energy (J) ISO-V</th>
<th>Hardness HRc</th>
</tr>
</thead>
<tbody>
<tr>
<td>1 layer</td>
<td>62-64</td>
<td></td>
<td></td>
<td>-20°C</td>
<td></td>
</tr>
<tr>
<td>2 layers</td>
<td>65-70</td>
<td></td>
<td></td>
<td>-40°C</td>
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</tbody>
</table>

AW: as welded

WELDING PARAMETERS / PACKING

<table>
<thead>
<tr>
<th>D (mm)</th>
<th>Length (mm)</th>
<th>Current (A)</th>
</tr>
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<tbody>
<tr>
<td>6.3</td>
<td>450</td>
<td>75-130</td>
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RÜCKTROCKNUNG
not required