



# Elgaloy Hard 60

REPAIR & MAINTENANCE

Other

Date: 2007-10-19  
Revision: 12

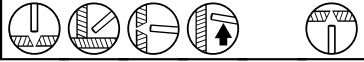
## Description:

Elgaloy Hard 60 produces a martensitic weld metal with a hardness of about 57-60 HRC. The crack-free deposit has good wear resistance under conditions of abrasion and friction coupled with moderate impact. Also available as a self-shielded flux cored wire, Elgaloy Hard R 60.

## Applications:

Excavator teeth, bulldozer blades, swing hammers, crusher jaws, scrapers etc.

## Welding positions:



## Shielding gas:

## Coating type:

Basic

## Metal recovery:

130%

## Hardness as welded:

57 - 60 HRC, 640 - 690 HV 10

## Welding current:

DC +, AC

## Chemical composition, wt.%

	C	Si	Mn	Cr	Mo	V
Min	0,6	0,6	0,5	7,0	0,4	0,3
Typical	0,7	0,8	0,8	8,0	0,5	0,4
Max	0,8	1,0	1,0	10,0	0,6	0,5

## Classification:

DIN 8555-83

E6-UM-55

## Approvals:

## Product data

Diam.mm	Product code	Current A	Voltage V	Delivery form
3,2	70313210	110-150		
4,0	70314010	150-190		