

Standards	DIN 8555	E 10-GF-UM-65-GTZ
	DIN EN 14700	E Fe15

Approvals ---

Characteristics Tubular electrode filled with chromium carbide powder, suitable for hardfacing on parts which are mainly subject to abrasive wear, but also to impact stress.
 High amount of Cr carbides in an austenitic matrix, very compact.
 Due to its special metallurgical composition, this electrode can be consumed with very low current. High hardness is achieved already in the first layer.
 Soft, quiet fusion. The weld metal is almost free of slag.
 A buffer layer of CARBO 4370 MPR is recommended prior to surfacing on old claddings.

Operating temperature ---

Typical applications Mainly used for hardfacing on pump bodies, mixer blades, agitator arms, concrete pumps, conveyer worms, and coke-oven slides, and agricultural machines, in civil engineering and in the cement industry.

Hardness of all-weld metal (typical values)	HRc 1st layer	HRc 3rd layer
	60	63

Weld metal analysis (typical, wt. %)	C	Mn	Cr	Others
	5.5	1,5	40	2

Current = + / ~ 50 V

Welding positions PA, PB

Rebaking 1 h, 150°C + / - 10 °C (if required)

Dia./Length	Amperage (A)	Pcs./ packet	Pcs./ carton	kg / 1000	kg / packet	kg / carton
6.0 x 457	80 - 110	67	268	74.6	5.0	20.0
8.0 x 457	120 - 140	38	152	131.6	5.0	20.0
11.0 x 457	140 - 180	22	88	227.3	5.0	20.0

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