

Dur 55

CATEGORY	SMAW Stick Electrodes	
TYPE	High efficiency hardfacing elektrode	
APPLICATIONS	Pomp bodies, mixer blades, agitator arms, concrete pumps	
PROPERTIES	DUR 55 is a heavy coated high efficiency hardfacing electrode with 160 % recovery. Suitable for applications subject to strong abrasive wear by minerals	
CLASSIFICATION	AWS	A 5.13: E FeCr-A1
	EN ISO	14700: E Fe14
	DIN	8555: E 10-UM-60-GR
SUITABLE FOR	54-62 HRc, hardfacing loaders, buckets, pumps, cement crushing equipment, screws, mixers blades etc., excelent abrasion resistance and high wear resistance	
APPROVALS	CE approved	

WELDING POSITIONS:



C	Mn	Si	Cr	Ni	Mo
4.5		1	28		

MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness HRc
				-20°C	-40°C	-60°C	
AW							57

WELDING PARAMETERS PACKING

D (mm)	Welding Parameters		kg / can	Packing	
	Length (mm)	Current (A)		kg / 6pack	kg / 1000
2.5	350	70-110			
3.2	350	90-130			
4.0	450	120-160			
5.0	450	180-260			

REDRYING TEMPERATURE 1hr/350°C