

Dur 600

CATEGORY	SMAW Stick Electrodes		
TYPE	Universal AC-weldable hard surfacing electrode		
APPLICATIONS	Suitable for deposits on mild steel, steel castings and manganese steel		
PROPERTIES	The electrode has a soft but intensive welding character, a fine-structured seam surface and excellent slag-removal properties		
CLASSIFICATION	EN ISO	14700: E Fe6	
	DIN	8555: E6-UM-60 GP	
SUITABLE FOR	Rollers, dredger chains, conveyors, hammers, dredger equipment, mining and earth-moving equipment		
APPROVALS	CE approved		

WELDING POSITIONS:



WELD METAL ANALYSIS %

C	Cr	Mn	Si
0.6	9	0.4	1.7

MECHANICAL PROPERTIES

Heat treatment	RT	Hardness
AW		HRc 59

AW: as welded

WELDING PARAMETERS / PACKING

Welding Parameters			Packing	
D (mm)	Length (mm)	Current (A)	kg / can	kg / 6 pack
2.5	350	60-90	2.5	15
3.2	450	90-120	2.5	15
4.0	450	110-160	3	18
5.0	450	150-200	3	18

REDRYING TEMPERATURE 350°C/1hr