

Dur 63 Nb

CATEGORY SMAW Stick Electrodes

TYPE Basic coated, high Chromium-Niobium based hardfacing alloy for SMAW

APPLICATIONS This electrode with a recovery of 190% can be used for overlays with extremely abrasive and sliding wear resistance, but with low impact. For use till 450°C.

PROPERTIES Very economical due to the high deposition rate and excellent weldability without slag losses. For critical base material or old hard facing layers it is necessary to buffer with an electrode like DUR E 350 Kb / E 11018-G that delivers a welding deposit of less hardness. Overlays on steel with high carbon content should be buffered with Croni 29/9 HL or 4370 HL. For the best results 2 till 3 layers should be welded.

CLASSIFICATION

AWS	A 5.13: no standard
EN ISO	14700: EZ Fe15
DIN	8555: E 10-UM-65-GRZ

SUITABLE FOR Sugar mill knives and hammers, cement mixers, clinker crushers, sintering lines, fire gratings, mixer blades, gravel washing equipment, ceramic mixer blades, extruders, crushing tables and rollers for lime stone etc.

APPROVALS CE approved

WELDING POSITIONS:



WELD METAL ANALYSIS %

C	Cr	Nb	Fe
5.5-6.0	22-26	5-7	rem

MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Hardness HRc		
				1st layer	2nd layer	3th layer
AW				57-60	59-62	61-65

WELDING PARAMETERS PACKING

D (mm)	Welding Parameters		Packing		
	Length (mm)	Current (A)	kg / can	kg / 6 pack	kg / 1000
3.2	350	100-160			
4.0	450	160-220			
5.0	450	190-250			

REDRYING TEMPERATURE 300-320 °C/2h

EQUIVALENT FCAW - OA 59 - OA 64