

Dur 71

CATEGORY SMAW Stick Electrodes

TYPE Basic coated electrode with a sintered tungsten carbide core wire.

APPLICATIONS For extreme wear resistance, elements as Niobium and Chromium carbides are also added to obtain a complex carbide structure. Specially used for applications subject to abrasive wear such as sand or other minerals with little impact. Recommended for the brick and clay industry or extreme high temperature applications in power plant industries.

PROPERTIES Ceweld Dur 71 is designed to offer full wear resistance and high hardness already achieved in the first layer. To be welded with low as possible current to avoid burnout of elements.

CLASSIFICATION

AWS	A 5.13: no standard
EN ISO	14700: EZ Fe20
DIN	8555: E 21-UM-65-G

SUITABLE FOR For extreme heavy abrasion and wear applications such as, mixers and screws in the brick and clay industry, electricity powerplant screws (ash), mining, drilling etc

APPROVALS CE approved

WELDING POSITIONS:



WELD METAL ANALYSIS %

WC	Cr3C2	Fe	Nb
70	7	rest	4

MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A5 (%)	Impact Energy (J) ISO-V		Hardness HRC	
				-20°C	-40°C	First layer	Second layer
AW						63-65	66-70

AW: as welded

WELDING PARAMETERS PACKING

D (mm)	Welding Parameters			Packing		
	Length (mm)	Current (A)	kg / can	kg / 6 pack	kg / 1000	
4.0	350	90-110			66.67	
5.0	350	110-130			125	

NOTE Preheating till 250°C and slow cooling down is recommended.