

Dur E 300 Kb

CATEGORY SMAW Stick Electrodes

TYPE Basic coated electrode for hardfacing machine parts, buffer layers and rebuilding rails and crossings..

APPLICATIONS hardfacing, rebuilding, overlays, machine parts, wheels, buffer layers, rails, crossings etc.

PROPERTIES Outstanding alloy against high impact combined with abrasion including metal to metal friction. The weld deposit of Dur E 300 Kb is an exceptional easy to apply alloy without any risk for cracks and can also be applied on austenitic manganese steels, 300 HB is usually already almost obtained in the first layer. The weld deposit is machinable with tungsten tool tips. Very good weld deposit appearance and outstanding welding properties on both AC and DC+. Preheating is not required.

CLASSIFICATION

AWS	A 5.13: E Fe1
EN ISO	14700: E Fe1
DIN	8555: E1-UM-300P

SUITABLE FOR Rebuilding worn machine parts, rails, crossings, Stone crushers, Hammers, Gears, Cams, bearings, rope winches etc...

APPROVALS CE approved

WELDING POSITIONS:



WELD METAL ANALYSIS %

C	Mn	Fe	Cr
0.1-0.15	1.0-1.5	rem	2.5-3.0

MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Hardness HB		
				1st layer	2nd layer	3th layer
AW				290	300	315

3 layers on mild steel

WELDING PARAMETERS / PACKING

Welding Parameters			Packing		
D (mm)	Length (mm)	Current (A)	kg / can	kg / 6 pack	kg / 1000
3.2	350	95-150	2.8	16.8	36
4.0	450	140-190	3,2	19,2	66
5.0	450	190-250	3,2	19,2	116

REDRYING TEMPERATURE 300°C/2hr