

## Dur E 60 Kb

**CATEGORY** SMAW Stick Electrodes

**TYPE** Basic coated, alloyed Cr-Mo-V electrode

**APPLICATIONS** Hardfacing against high impact combined with strong abrasion wear.

**PROPERTIES** Outstanding alloy against high impact combined with abrasion including metal into metal friction. The weld deposit of Ceweld Dur E 60 Kb is one of the most universal alloys in hardfacing applications and can also be applied on austenitic manganese steels. Very good weld deposit appearance and outstanding welding properties on both AC and DC+. Preheating is not required.

**CLASSIFICATION**

AWS	A 5.13:E Fe3
EN ISO	14700: E Fe8
DIN: W.Nr.	1.4718
DIN	8555: E6-UM-60

**SUITABLE FOR** Mixing arms, cold cutting tools, hammers, rolls, loaders, buckets, pumps, hardfacing on austenitic manganese steel, rebuilding knives

**APPROVALS** CE approved

**WELDING POSITIONS:**



**WELD METAL ANALYSIS %**

C	Cr	Mn	Mo	V	Fe
0.5-0.8	7-10	0.5-0.7	0.5-1.0	1.0-1.2	rem

**MECHANICAL PROPERTIES**

Heat treatment	Hardness RT
AW	54-60 HRC

AW: as welded

**WELDING PARAMETERS / PACKING**

Welding Parameters			Packing		
D (mm)	Length (mm)	Current (A)	kg / can	kg / 6 pack	kg / 1000
2.5	350	80-120	3.00	18.00	
3.2	450	100-160	3.30	19.80	
4.0	450	160-220	3.50	21.00	
5.0	450	190-260	3.30	18.00	

**REDRYING TEMPERATURE** 300°C/2hr

**EQUIVALENTS** GMAW - MA 600 / FCAW Megafil A 760M