

DUR E 600 KB

CATEGORY SMAW Stick Electrodes

TYPE Basic coated electrode for rebuilding machine parts and hardfacing wear parts.

APPLICATIONS Hardfacing, rebuilding, overlays on machine parts and wear parts in mining, agriculture etc.

PROPERTIES Dur E 600 Kb is a basic coated electrode with approximately 130% recovery that leaves a fine rippled seam surface with excellent impact and wear properties. The weld deposit shows a martensitic structure with good increased temperature properties and can resist oxidation upto 800°C. The deposit is heat treatable and offers excellent sliding and rolling properties.

CLASSIFICATION EN ISO EN 14700: E Z Fe8
DIN 8555: E6-UM-60-GP

SUITABLE FOR Rebuilding worn machine parts, Stone crushers, Hammers, Gears, Cams, metal scrap and car recycling hammers, cold cutting tools, slurry pumps etc.

APPROVALS CE approved

WELDING POSITIONS:



WELD METAL ANALYSIS %

C	Cr	Mo	V	Fe
0.6	8,7	0.5	1.4	Rest

MECHANICAL PROPERTIES

Heat Treatment	Rp0,2 (N/mm ²)	Rm (N/mm ²)	A5 (%)	Impact Energy (J) ISO-V			Hardness HRC
				-20°C	-40°C	-60°C	
AW							57-61

WELDING PARAMETERS / PACKING

Welding Parameters			Packing	
D (mm)	Length (mm)	Current (A) (DC+)	kg / can	kg / 6pack
2.5	350	70-90	2.4	14.4
3.2	350/450	100-135	2.4	14.4
4.0	450	140-180	3.0	18.0
5.0	450	180-230	3.2	19.2

REDRYING TEMPERATURE 400°C/1hr

EQUIVALENTS GMAW - MA 600