

## Dur MnCr

<b>CATEGORY</b>	SMAW Stick Electrodes
<b>TYPE</b>	Basic hardfacing electrode with high impact and wear resistance
<b>APPLICATIONS</b>	Basic electrode for rebuilding and joining cold straining Mn steels or rebuilding parts that are subject to high impact and rolling wear.
<b>PROPERTIES</b>	There is no limit for the number of layers that can be applied in case of rebuilding but heat input should be kept low (as for Mn steel, interpass temperature should be kept <250°C).
<b>CLASSIFICATION</b>	AWS A 5.13: E FeMnCr EN ISO 14700: E Fe9 DIN 8555: E 7-UM-250-K
<b>SUITABLE FOR</b>	rebuilding and joining cold straining Mn steels or rebuilding parts that are subject to high impact and rolling wear. Breaker teeth, crushers, hammers, crossings, rails.

**APPROVALS** CE approved

**WELDING POSITIONS:**



**WELD METAL ANALYSIS %**

C	Mn	Cr	Fe
0.5-0.6	16-18	13-15	bal

**MECHANICAL PROPERTIES**

Heat Treatment	Rp0,2 (N/mm <sup>2</sup> )	Rm (N/mm <sup>2</sup> )	A5 (%)	Impact Energy (J) ISO-V			Hardness HB
				-20°C	-40°C	-60°C	
AW							220-450

AW: as welded, 450 HB strain hardening

**WELDING PARAMETERS / PACKING**

Welding Parameters			Packing		
D (mm)	Length (mm)	Current (A) (DC+/AC)	kg / can	kg / 6 pack	kg / 1000
3.2	350	100-160	2.5	15	68
4.0	450	160-220	3.0	18	100
5.0	450	190-260	3.1	18.6	139

**REDRYING TEMPERATURE** 300C / 2hr