

DUR SS 60 Ti

CATEGORY SMAW Stick Electrodes

TYPE Hardfacing electrode for cutting edges and many overlay applications.

APPLICATIONS Developed for wear resistant overlays that faces high working temperatures and excellent for rebuilding cutting edges of knives and other cutting equipment.

PROPERTIES Outstanding alloy against abrasion, impact and high temperatures up-to 550°C. The weld deposit of Ceweld Dur SS 60Ti is more or less comparable with HSS (High Speed Steel) and will offer outstanding welding properties on both AC and DC+ Recommended for manufacturing and reconditioning cutting tools.

CLASSIFICATION

AWS	A 5.13: E Fe5-R
EN ISO	14700: E Fe4
DIN: W.Nr.	1.3348
DIN	8555: E 4-UM-60(65W)-ST

SUITABLE FOR Cutting tools, Shear blades, Milling cutters, Drills, Hot work tools, wood knives etc. High speed Tool steel deposit.

APPROVALS CE approved

WELDING POSITIONS:



WELD METAL ANALYSIS %

C	Mn	V	Cr	W	Mo	Fe
0.8-1.0	1,50	1.2-1.8	4.0-5.0	1.5-2.5	7-9	Rem

MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Hardness HRc		
				20°C	-40°C	-60°C
AW				58-62		
HT				62-65		

AW: as welded, HT: heat treatment

WELDING PARAMETERS / PACKING

D (mm)	Welding Parameters			Packing	
	Length (mm)	Current (A)	kg / can	kg / 6 pack	kg / 1000
2.5	350	50-90	2.4	14.4	
3.2	350	90-140	2.5	15	
4.0	350	120-160	2.5	15	
5.0	350	140-180			

EQUIVALENT FCAW - OA SS 60