

Dur 64

CATEGORY	SMAW Stick Electrodes																																	
TYPE	Basic coated, high Chromium-Niobium based hardfacing high recovery hardfacing electrode																																	
APPLICATIONS	This electrode with a recovery of 190% can be used for overlays with extremely abrasive and sliding wear resistance, but with middle impact.																																	
PROPERTIES	Due to the high Mo-content, abrasion resistance can be kept up to working temperatures of 600°C ; the hardness is still 40-45 HRC at these temperatures. For hardfacing of more than 3 layers it is necessary to buffer with an electrode like DUR E 350 Kb that delivers a welding deposit of less hardness. Overlays on steel with high tensile strength have to be buffered with Croni 29/9 HL or 4370 HL. Equivalent in FCAW: OA 64																																	
CLASSIFICATION	AWS	A 5.13: E FeCr-E4																																
	EN ISO	14700: E Fe16																																
	DIN	8555: E 10-UM-65-Z																																
SUITABLE FOR	Sugar mill knives and hammers, clinker crushers, sintering lines, fire gratings, mixer blades, gravel washing equipment, ceramic mixer blades, mill rollers, stone crushers, extruders etc....																																	
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WELDING POSITIONS:																																		
WELD METAL ANALYSIS %	<table border="1"> <thead> <tr> <th>C</th> <th>V</th> <th>W</th> <th>Cr</th> <th>Nb</th> <th>Mo</th> </tr> </thead> <tbody> <tr> <td>4.0-6.0</td> <td>0.8-1.2</td> <td>1.8-2.2</td> <td>22.0-25.0</td> <td>5.0-7.0</td> <td>5.0-7.0</td> </tr> </tbody> </table>					C	V	W	Cr	Nb	Mo	4.0-6.0	0.8-1.2	1.8-2.2	22.0-25.0	5.0-7.0	5.0-7.0																	
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