OK 84.78

SMAW

Type Rutile-basic E10-UM-60-CZ

Description

Electrode producing a weld metal with coarse chromium carbides in an austenitic matrix. Suitable for surfacing worn parts exposed to abrasion and wear by coal, ore or other minerals. Typical applications include earth-moving machines, mixers, feeder screws, dust exhausters and crushers. It can also be used on components operating in corrosive environments and/or at elevated temperatures.

Welding current

AC, DC+ OCV 50 V

Classifications

DIN 8555 E10-UM-60-CZ

Typical all weld metal composition, %

C	Si	Mn	Cr
4.5	0.8	<1.6	33

Typical mech. properties all weld metal

Weld metal hardness, a w	59-63 HRC
No preheat and interpass temperature 100°C:	
3rd layer:	59-63 HRC
Preheat and interpass temperature 500°C:	
3rd layer:	55-61 HRC
Machinability	Grinding only
Abrasion resistance	Excellent
High temp. wear resistance	Good
Corrosion resistance	Excellent

Tempering resistance

Temp°C/1h	HRC
100	58
300	59
400	57
490	59
600	57
700	58

Deposition data at max current

Diameter, mm	Length, mm	Welding current, A	Arc voltage, V	N. Kg weld metal/kg electrodes	B. No. of electrodes/kg weld metal	H. Kg weld metal/hour arc time	T. Burn-off time, s/ electrode
2.5	350	90-120	24	0.62	48.0	1.2	60
3.2	350	115-170	24	0.62	26.0	1.6	85
4.0	450	130-210	26	0.64	13.5	2.0	135
5.0	450	150-300	26	0.64	9.0	2.9	140