



ELHARD 600 S

Standards :

TS EN 14700	:	E Fe 8
EN 14700	:	E Fe 8
DIN 8555	:	E6-UM-60 P

Chemical Composition of Weld Metal- % (Typical) :

C	Si	Cr
0.50	1.80	9.00

Mechanical Properties :

Weld Metal Hardness As Welded (HRC)	Soft Annealing	Hardening	Tempered
54 - 58	780 - 820°C Slow Cooling in Furnace	1000 - 1050°C in oil	300 - 400°C

Typical Base Material Grades :

* Applicability in final-layer hardfacing of parts of earth and mineral mining machines, impact drilling and crushing devices, guide springs, edges of cutting tools, hard manganese steels, bucket edges and teeth, all of which are made of alloyed or unalloyed steels, as well as in other materials required to have high resistance to wear.
 * Electrode of basic type with thick coating.* Inclusion of chromium-silicon alloy, very hard electrode.
 * Weld metal with ductile and cracking-resistant behaviors.* Crack resistance to impact forcing due to its high ductility.*
 * Machinability of weld metal through grinding only.* Requirement of re-drying at 300 °C for 2 hours for moistened electrodes.* Recommended pre-heating at 200-300 °C for welding thick work pieces and materials tending to get hardened.* Requirement of 2-3 layers hardfacing to obtain the highest resistance to wear.
 * Suitability of harder and/or higher-quality steels to buffer-layering with the GeKa electrodes LASER B 50, TEMPO B 63, or, in some cases, with the GeKa electrodes such as ELOX B307, ELOX R 312.
 * Re-drying : 300° C / 2h.

Welding Positions :



Current Type :

D.C.(+)

Operating Data :

Product Code	Diameter x Length (mm) / (inch)		Welding Current (A)	Weight g /100 pcs
303478	2.50 x 350	3/32 x 14"	60 - 100	2430
303482	3.20 x 350	1/8 x 14"	100 - 140	3570
303484	4.00 x 450	5/32 x 18"	140 - 180	6780
303488	5.00 x 450	3/16 x 18"	180 - 230	10660

Approvals :

CE, GOST-R, SEPRO