

## Coated Electrode for Overlay Welding and Hardfacing

### Classification

DIN 8555 : E2-UM-60 Z  
EN 14700 : E Fe4

### General Description

AS SD-65 is a basic coated electrode. It gives a high oxidation resistant (up to 850°C) weld metal that also have a high wear resistance. It is resistant to wears of medium abrasions at high temperatures.

### Chemical Composition (w%), Typical, All Weld Metal

C	Si	Mn	Cr
0.70	4	0.30	2

### Mechanical Properties, Typical, All Weld Metal

Hardness : 57 - 62 HRC (3 passes, no preheating)  
50 - 60 HRC (3 passes, 300°C preheating)

### Approvals

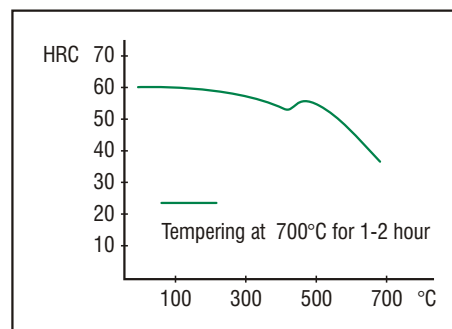
GOST, SEPRO, TSE

### Applications

It is particularly used for repair applications of machine parts that are particularly exposed to wear by stone, coal, sand and soil. Loading machines, band plates, wear plates and parts of grinders can be hardfaced with this electrode. It is recommended to use AS SD-65 in high temperature applications where oxidation resistance is more important than hardness and resistance to tempering like feed screws in furnaces.

**Hardening** : in oil or air at 920 - 980°C

**Softening** : in furnace at 680 - 700°C



### Welding Parameters / Packing and Diameter Informations / Welding Positions

Current Type and Polarity : DC (+) ; AC min 70 V

Diameter [ mm ]	Length [ mm ]	Current [ A ]	Electrode Weight [ g/100 pcs ]	Box Weight [ kg ] Quantity [ pcs/box ]	Export Box Box Weight [ kg ]
3.25	350	100 - 140	3370	4.7 / 140	5
4.00	450	150 - 180	6660	6.3 / 95	6
5.00	450	180 - 225	9790	6.4 / 65	6



1G/PA



2F/PB