

Coated Electrode for Overlay Welding and Hardfacing

Classification

DIN 8555 : E10-UM-60 G
 EN 14700 : E Fe15
 AWS A5.13 : E FeCr-A1

General Description

AS SD-ABRA Cr is a basic coated electrode that is highly resistant to abrasion wear caused by coarse hard minerals. It has a highly concentrated chromium carbide in its structure.

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

C	Cr
4.5	33

Mechanical Properties, Typical, All Weld Metal

Hardness : 58 - 62 HRC
 Carbide hardness : 1400 - 1500 HV

Approvals

GOST, SEPRO, TSE

Applications

Bucket conveyors, extruder screws, dragline buckets, dredgers, scrapers, screw conveyors, press screws, heads in ceramic industry, mixer blades and grinding rollers can be hardfaced with AS SD-ABRA Cr.

It should not be used for more than three passes. Interpass temperature should be 300-500°C.

In applications requiring a thick deposit metal, AS P-308Mn or AS P-312 should be used for buffering. It is crucial to have a buffer layer with AS P-308Mn for 12-14 % Mn containing steels before hardfacing applications.

Welding Parameters / Packing and Diameter Informations / Welding Positions

Current Type and Polarity : DC (+) ; AC min 65 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	115 - 160	5760	4.6 / 80	5
4.00	350	120 - 190	9140	4.6 / 50	5



1G/PA



2F/PB