

Coated Electrode for Overlay Welding and Hardfacing

Classification

DIN 8555 : (E10-UM-60 GR)
EN 14700 : E Fe15

General Description

AS SD-ABRA Nb is a basic coated electrode that is highly resistant to abrasion wear caused by fine or coarse hard minerals. Concentrated Cr and Nb carbides have been finely dispersed in its structure. In corrosive environments, it gives a better resistance to wear caused by fine minerals than hardfaced structures having an ordinary chromium carbide structure.

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

C	Cr	Nb
3.4	22	10

Mechanical Properties, Typical, All Weld Metal

Hardness : 55 - 57 HRC
Carbide hardness : >1500 HV

Approvals

GOST, SEPRO, TSE

Applications

Wear plates, dredgers, rock crushers, grinding hammers and rollers can be hardfaced with AS SD-ABRA Nb. It should not be used for more than three passes.

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	100 - 150	5750	4.6 / 80	5
4.00	350	140 - 200	8930	4.5 / 50	5



1G/PA



2F/PB