

Coated Electrode for Overlay Welding and Hardfacing

Classification

DIN 8555 : E6-UM-55 R
EN 14700 : E Fe8

General Description

AS SD-CR 10 is a basic coated electrode. Wear resistant weld metal has a high toughness value and exhibits a high resistance to cracking at operating conditions with high impact. The highest wear resistance is obtained after three passes. 10 % Cr content increases the wear resistance of the weld metal to the simpler forms of corrosive attack. The weld metal is resistant to softening up to 500°C. It can be machined by grinding.

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

C	Si	Mn	Cr
0.70	0.60	0.70	10

Mechanical Properties, Typical, All Weld Metal

Hardness : 52 - 56 HRC

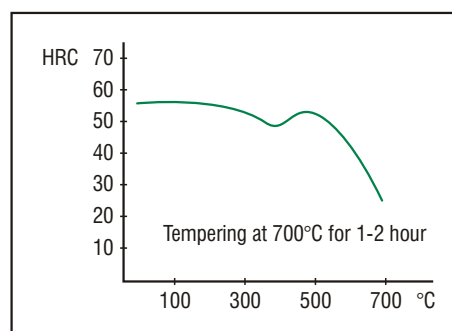
Approvals

GOST, SEPRO, TSE

Applications

It is used for hardfacing of alloyed and unalloyed steels. Worn surfaces of crushing tools in the mining industry, conveyor screws, excavator bucket and teeth, excavator and bulldozer blades, mixer parts, screws of cement pumps, and cutting edges of cold worked tool steels can be hardfaced with AS SD-CR 10.

While there is no need to have a buffer layer for unalloyed steels up to St 70; for high alloyed steels, it is recommended to have a buffer layer with AS B-248 or AS B-255, and in special cases with AS P-308Mn or AS P-312.



Hardening : in oil or air at 950-1000°C

Softening : in furnace at 850°C

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	110 - 140	4340	4.8 / 110	5
4.00	450	150 - 190	8410	6.3 / 75	6
5.00	450	180 - 240	13460	6.1 / 45	6



1G/PA



2F/PB



2G/PC