

Coated Electrode for Overlay Welding and Hardfacing

Classification

DIN 8555 : E5-UM-45 R
EN 14700 : E Fe7

General Description

AS SD-CR 13 is a rutile coated electrode. It gives a corrosion and wear resistant ferritic-martensitic stainless steel weld metal. It is used in hardfacing applications where a hardness of 42-46 HRC is required. The weld metal is resistant to softening up to 500°C.

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

C	Si	Mn	Cr
0.10	0.50	0.30	13

Mechanical Properties, Typical, All Weld Metal

Hardness : 42 - 45 HRC

Approvals

GOST, SEPRO, TSE

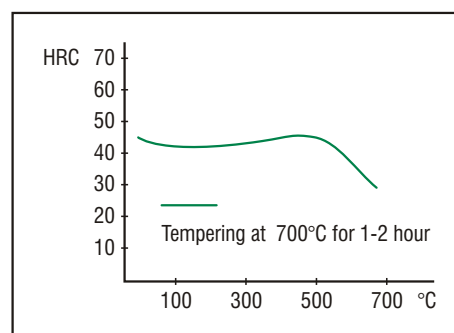
Applications

It is used for hardfacing of alloyed and unalloyed steels. Worn surfaces of rails and rail surfaces, crane and conveyor wheels, cast steel valve seats, pinions, track rollers and links of earthmoving equipment can be hardfaced with AS SD-CR 13. It can also be used for joining of low carbon steels having 13% Cr.

It is recommended to use AS SD-CR 10 in multipass applications as it is a basic coated electrode. It is also recommended to have a preheating and interpass temperature of minimum 200°C.

Hardening : in oil or air at 980-1000°C

Softening : in furnace at 780 - 800°C



Welding Parameters / Packing and Diameter Informations / Welding Positions

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

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 - 160	4640	4.6 / 100	5
4.00	350	140 - 200	6880	4.5 / 65	5
5.00	350	180 - 240	10600	4.8 / 45	5



1G/PA



2F/PB



2G/PC