

## Coated Electrode for Overlay Welding and Hardfacing

### Classification

DIN 8555 : E4-UM-60 (65) S  
EN 14700 : E Fe4

### General Description

AS SD-HSS is a basic coated electrode. It gives a Mo alloyed, high speed steel type weld metal. Deposited metal retains its toughness properties at high temperatures enabling the formation of high strength welds, particularly during the hardfacing of cutting and punching tools.

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

C	Si	Mn	Cr	Mo	W	V
0.90	1.20	1.30	4.5	7.5	1.80	1.50

### Mechanical Properties, Typical, All Weld Metal

Hardness : 57 - 60 HRC (as welded)  
65 HRC (after double tempering)

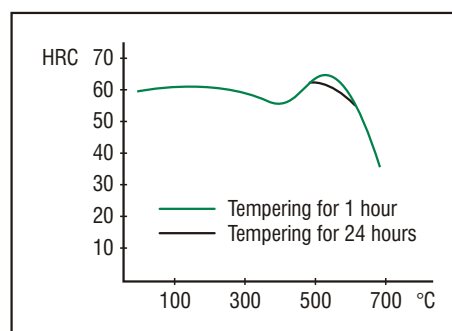
### Approvals

GOST, SEPRO, TSE

### Applications

It is particularly used for hardfacing of cutting and punching tools made of alloyed and unalloyed steels with a hot tool steel structured weld metal. Part that is going to be welded should be preheated to 400-500°C and small beads should be preferred to inhibit overheating.

Machine tools, drilling parts, and tools made of high speed steels are among other application areas.



### 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 ]
2.50	350	70 - 100	2580	2.1 / 80	5
3.25	350	100 - 140	4370	2.2 / 50	5
4.00	350	150 - 185	6680	2.0 / 30	5



1G/PA



2F/PB