

## DURWELD 300

Electrodes MMA [SMAW]

Hardfacing and repairing

|                                                   |                   |                          |
|---------------------------------------------------|-------------------|--------------------------|
| <b>CLASSIFICATION:</b>                            | <b>APPROVALS:</b> | <b>APPLICATION:</b>      |
| EN ISO 14700-A : E Fe3<br>DIN 8555 : E 1-UM-300 P | UDT               | Hardfacing and repairing |

- Hardfacing electrode with Cr.
- Excellent slag release, low spatter.
- The joint is covered with an uniform, very fine scale.
- For the regeneration of elements exposed to high impact and medium abrasion.
- Recommended for surfacing parts exposed to wear.

### Application

Road wheels, gear wheels, chain links, rails, rolling mill components, couplings, etc.

### Base material

Steel  
Cast steels

### Typical chemical composition %

|          |           |           |
|----------|-----------|-----------|
| <b>C</b> | <b>Mn</b> | <b>Cr</b> |
| 0,18     | 1,00      | 1,20      |

### Typical mechanical properties

|                 |                                                                                                                                                                  |
|-----------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| <b>Hardness</b> | 275 - 325 HB / The hardness of the overlay depends on the relevant welding conditions, the number of layers and the chemical composition of the base material. / |
|-----------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------|

|                     |       |
|---------------------|-------|
| <b>Coating type</b> | basic |
|---------------------|-------|

|                        |                                                                                     |
|------------------------|-------------------------------------------------------------------------------------|
| <b>Welding current</b> |  |
|------------------------|-------------------------------------------------------------------------------------|

|                          |                                                                                     |
|--------------------------|-------------------------------------------------------------------------------------|
| <b>Welding positions</b> |  |
|--------------------------|-------------------------------------------------------------------------------------|

|                 |                             |
|-----------------|-----------------------------|
| <b>Redrying</b> | 400°C / 1 h lub 300°C / 2 h |
|-----------------|-----------------------------|

### Welding parameters and packing

| Ø   | Length [mm] | Welding current [A] | Weight of packet [kg] | Weight of carton [kg] | Pcs/1 kg |
|-----|-------------|---------------------|-----------------------|-----------------------|----------|
| 2,5 | 350 /       | 70-90               | 4,0                   | 12,0                  | 60       |
| 3,2 | 350 /       | 100-135             | 4,5                   | 13,5                  | 28       |
| 4,0 | 450 /       | 130-170             | 5,5                   | 16,5                  | 14       |
| 5,0 | 450 /       | 180-220             | 5,5                   | 16,5                  | 9        |

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