

# DURWELD 600

Electrodes MMA [SMAW]

Hardfacing and repairing

<b>CLASSIFICATION:</b>	<b>APPROVALS:</b>	<b>APPLICATION:</b>
EN ISO 14700-A : E Fe8 DIN 8555 : E 6-UM-60 P	UDT	Hardfacing and repairing

- Electrode for hardfacing steel elements exposed to high impact.
- Excellent slag release, low spatter.
- The joint is covered with an uniform, very fine scale.
- Overlay with a hardness of 57-62 HRC, with medium resistance to abrasion.
- For hardfacing of parts exposed to high impact and abrasion by stone, coal, sand, etc.
- The deposit can be machined by grinding and gouging.

### Recommendations:

- Keep a short arc.
- Preheating of low-alloy steels is not necessary.
- Large, heavy materials with high tensile strength, heat to 250-300°C.
- If more than 3 layers are required, build up with DURWELD 300 or softer.
- For higher manganese content steels, high carbon steels and hardenability enhancing ingredients, use INOX B307 buffer.



### Base material

Steel  
Cast steels

### Typical chemical composition %

<b>C</b>	<b>Cr</b>
0,50	5,00

### Typical mechanical properties

<b>Hardness</b>	57 - 62 HRC / 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 or 300°C / 2 h

### Welding parameters and packing

∅	Length [mm]	Welding current [A]	Weight of packet [kg]	Weight of carton [kg]	Pcs/1 kg
3,2	350 /	100-135	4,5	13,5	27
4,0	450 /	140-180	5,8	17,4	14
5,0	450 /	180-230	5,5	16,5	9

6,0

450 /

230-280

5,0

15,0

5

**METALWELD-FIPROM POLSKA spółka z o.o.**

ul. Mikołajczyka 57, 41-200 Sosnowiec

+48 (32) 297 75 50 - 51

+48 (32) 297 75 88

export@metalweld.pl