

### CLASSIFICATIONS

EN 14700 : E Fe 8  
DIN 8555 : E6-UM-60 P

### DESCRIPTION

- Electrode covering of rutile character
- Usability with a welding transformer (Weldability with AC)
- Weld metal with ductile and cracking-resistant behaviors
- Requirement of re-drying at the temperature range of 300°C-350°C for 2 hours
- Applicability in final layer welding of earth and mineral mining machines. Impact drilling and crushing devices, guide springs, edges of cutting tools, hard manganese steels, bucket edges and teeth

### CHEMICAL ANALYSIS OF WELD METAL % (TYPICAL)

C: 0.5 | Mn: 0.3 | Si: 1.1 | Mo: 1.0 | V: 1.0 | Cr: 7.0

### MECHANICAL PROPERTIES

#### Weld Metal Hardness (HRC)

55 - 59

### WELDING POSITIONS



### CURRENT CONDITION

D.C.(+) / A.C.

### OPERATING DATA

Product Code	Diameter x Length (mm) / (inch)		Welding Current (A)	Weight g / 100 pcs
2010800358	3.20 x 350	1/8 x 14"	90 - 135	4170
2010800359	4.00 x 450	5/32 x 18"	135 - 180	7640
2010800360	5.00 x 450	3/16 x 18"	180 - 230	11670