



Coated Electrode for Overlay Welding and Hardfacing

Classification

DIN 8555 : E6-UM-60
EN 14700 : E Fe4

General Description

AS SD-60 is a general purpose, rutile coated hardfacing electrode especially designed to use with small transformers having a relatively low open circuit voltage. It is resistant to softening up to 500°C. It gives a high abrasion resistant martensitic type weld metal with a medium toughness. Weld metal can not be machined.

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

C	Si	Mn	Cr	Mo
0.40	0.40	0.50	6	0.60

Mechanical Properties, Typical, All Weld Metal

Hardness : 57 - 62 HRC

Approvals

GOST, SEPRO, TSE

Applications

It is used for hardfacing of alloyed and unalloyed steels. Protective lining of worn surfaces of machines used in mines, bulldozer blades, excavator teeth, crushing jaws, conveyors, agricultural and forestry machines that are exposed to wear can be hardfaced with this electrode.

Welding Parameters / Packing and Diameter Informations / Welding Positions

Current Type and Polarity : AC min 65 V ; DC (+)

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	60 - 120	2450	1.8 / 75	2
3.25	350	100 - 160	4190	4.4 / 105	5
4.00	450	130 - 190	8040	5.6 / 70	6
5.00	450	170 - 240	12760	5.7 / 45	6



1G/PA



2F/PB