

Electrodes for recharging new parts, to protect areas that wear out quickly, and for repairing worn parts. Resistant to abrasion and shocks, they are very easy to ignite, even with low arc voltage equipment.

Classification

EN 14700 : E Fe 2
DIN 8555 : E2-UM-60

Applications

- Reloading dies,
- Scrapers,
- Buckets and bucket teeth,
- Excavation equipment,
- Chisels,
- Conveyor screws,
- Caterpillar links.

Products' advantages

- High resistance to abrasion and impact.
- Good resistance to hot wear.
- Soft fusion
- Good weld bead aspect.
- Easy-to-remove slag.
- Few projections.

Positions and polarity



- Priming from 45V - Continuous current.
- **Electrode polarity (-).**

Chemical properties

C %	Si %	Mn %	P %	Cr %	Fe %
1.00	0.50	1.30	0.015	4.50	base

Mechanical properties

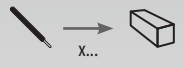
Brinell hardness HB	Rockwell HRC hardness
580-610	55-60

Recommendations

Ø electrode (mm)	2,5	3,2	4
thickness (mm)	2,5 ▶ 6	5 ▶ 8	8 ▶ +
welding current (A)	90	115	160



Packaging

Ref.	Ø (mm)	length (mm)	
A	081529	Ø 3.2	450 141
	081512	Ø 4.0	450 90
B	081543	Ø 2.5	350 46
	081574	Ø 3.2	450 22
	081581	Ø 4.0	450 14