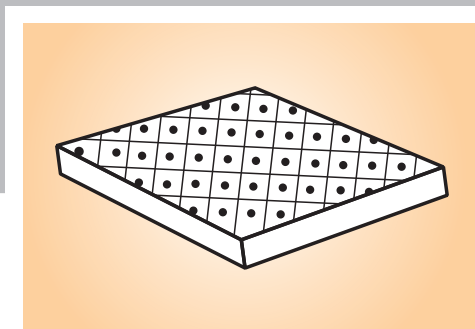


ESSEN® DUR 650 KB

AC/ DC +

DIN 8555 E 6 - UM - 60 G

An Electrode Having Very Good Abrasion Resistance Properties..



PROPERTIES

An electrode for Surfacing of parts subjected to abrasion. Chromium - carbide type of deposits resist wear due to abrasion combined with medium impact, can be built up on any steel material directly.

MECHANICAL PROPERTIES

57 - 62 Hrc

APPLICATIONS

For Effective Surface Protection (ESP) of parts subjected to abrasion like Excavator Buckets, Tooth points, Dozer Blades, Shear Blades, I.D. fan Blades, Scrapers etc

WELDING PROCEDURE

Clean the surface. Preheating upto 200° to 300° C may be required to avoid cracks. For heavy build up a base layer of ESSEN DUR 400 OR ESSEN MN14 is recommended. Multi layers are possible. The weld deposit can be grind finished.

RECOMMENDED AMPERAGE	
Size	Current
3.15 mm x 350 mm	100 - 160 Amps
4.00 mm x 350 mm	130 - 180 Amps
5.00mm x 350mm	175 - 230 Amps

PACKING	
3.15 mm x 350 mm 5 kg	29 pcs/kg (Approx.)
4.00 mm x 350 mm 5 kg	18 pcs/kg (Approx.)
5.00 mm x 350mm 5 Kg	14 pcs/kg (Approx.)



ESSEN
WELDING ALLOYS PVT. LTD.



ESSEN & AZUCAR
PREMIUM WELDING ALLOYS

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PUNE, VIDE REGD. T.M. NO. 543993 B.

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