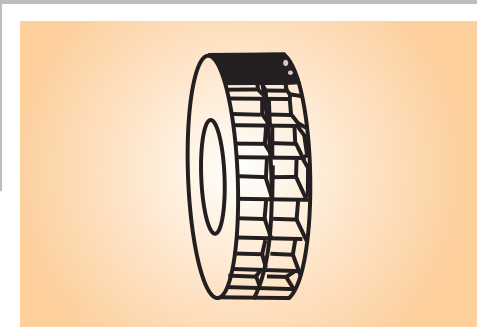


ESSEN® DUR CCR65

AC/ DC +

DIN 8555 E 10 - UM - 65 GRTZ

A Slagless Electrode for Excellent Abrasion Resistance.



PROPERTIES

An electrode giving deposits of complex carbides of Cr, Nb, W, V in an austenitic matrix. The weld deposits are highly resistant to severe abrasive wear. Gives a high hardness in the single layer only because of low dilution and slagless characteristics. Therefore no need of multilayers. The crack sensitivity of the weld deposits can be reduced by preheating. Retains hardness at elevated temperatures.

MECHANICAL PROPERTIES

Hardness : 62 - 67 RC

APPLICATIONS

For Effective Surface Protection (ESP) due to severe abrasion on mining & steel works parts like Excavator Bucket lip area, tooth points, Dozer Blades, Cutting edges & end bits, Sinter crushers in the steel plants, punches, dies & pneumatic drills etc

WELDING PROCEDURE

Clean weld area. Preheating may be necessary for heavy sections. Hold the electrode at near vertical position and direct the arc on previously welded deposit. Back whip to fill up the crater before lifting the electrodes. Use skip or staggering technique to prevent heat built up.

RECOMMENDED AMPERAGE	
Size	Current
3.15 mm x 350 mm	120 - 160 Amps
4.00 mm x 350 mm	130 - 180 Amps

PACKING	
3.15 mm x 350 mm 5 kg	15 pcs/kg (Approx.)
4.00 mm x 350 mm 5 kg	11 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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