

Standards

DIN 8555	E – UM 6-55.GP
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Characteristics CARBODUR 760 B is a basic coated electrode that gives a martensitic deposit with imbedded Nb-carbides, It is as well crack resistant, as resistant to high impact.
Due to the Nb-carbides the deposit is also resistant to abrasive wear.
The electrode is specially designed for the repair of similar base materials, also for similar alloys with Ti-carbides.

Typical applications Sand preparing plants, cement crusher rolls, ceramic industry, brick industry, crushing units, breaker bars, hammer mills etc.

Hardness and recommendations for heat treatment

HRc	as welded
50 - 55	

Weld metal analysis (typical. wt %)

C	Si	Mn	Cr	Nb
1,2	1,2	1,2	9	4

Current = + / partly ~ / 70 V

Welding positions PA. PB. PC. PD. PE

Rebaking 1 h. 200 °C + (if required)

Flux-cored wire equivalent

CARBO F- 760

Dia./Length	Amperage (A)	Pcs./ packet	Pcs./ car- ton	kg / 1000	kg / packet	kg / car- ton
2,5 x 350	50 - 80	227	909	22,0	5,0	20,0
3,2 x 450	70 - 110	126	503	47,7	6,0	24,0
4,0 x 450	100 - 150	83	332	72,3	6,0	24,0
5,0 x 450	140 - 190	53	213	112,9	6,0	24,0
6,0 x 450	170 - 230	37	148	162,6	6,0	24,0

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