

CARBO DURIT S 70 E

Standards	DIN 8555	E21-UM-65-G
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Characteristics CARBO DURIT S 70 E a hard metal electrode with a sintered tungsten carbide core with an addition of Cr and Nb carbides and a coating for the electric welding process.
It is designed for hardfacing of parts exposed to extreme abrasion.

Operating temperature ---

Typical applications It is used for applications where strongest abrasion by minerals with little impact may occur for example brick and clay industry.

Recommendations for best welding results To get a good result the welding areas should be properly cleaned of rust, grease, tinder and similar pollutions.
Preheat the area to be overlaid to 250°C – 350°C.
Best results are given by welding at low amperage, not more than 2 layers.
Gradual cooling is advised.

Hardness of weld metal (typical values)	1. layer	2. layer
	63 – 65 HRc	66 – 70 HRc

Weld metal analysis % (typical)	WC	Cr₃C₂	Nb	Fe
	70	7	4	Rest

Dia./Length	Amperage (A)	Pcs./ packet	Pcs./ carton	kg / 1000	kg/packet
4,0 x 350	120-140				20,0
5,0 x 350	140-170				20,0
6,0 x 350	170-220				24,0

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