

## ZULFI E 600B HF

### Properties

Thick graphite coated electrode depositing weld metal with chromium carbides. It is suitable for highly wear resistant overlays subject to abrasion. A buffer layer is necessary for the third layer.

### Application

Wearing parts subject to mineral abrasion such as conveyor screws, mixer blades, concrete pump parts, excavator bucket edges and also parts in petrochemical applications.

### Weld Metal Analysis Typical values

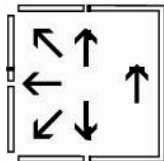
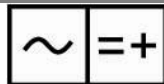
Carbon: 0.50
Silicon: 0.40
Manganese: 0.30
Chromium: 7.00
Molybdenum: 0.50
Vanadium: 0.50

### Typical Mechanical properties

Hardness(As Welded)

58-63 HRC

### Welding Current & Positions



### Current

Dia	Length	Amperes
2.6	300	60-80
3.2	350	100-140
4.0	350	140-190
5.0	350	190-250