

ZULFI E 600 HF

Properties

Thick graphite coated electrode depositing weld metal with chromium carbides. It is suitable for highly wear resistant overlays subject to abrasion. The typical transverse cracks occurring in such a hard weld metal are not detrimental for abrasion resistance. It is machinable only by grinding. 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

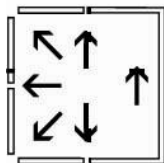
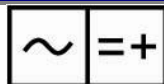
Carbon: 2.00
Chromium: 10.0
Manganese: 1.60

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