

EH 247

Standards

AWS/ASME SFA - 5.13	E FeMn-C
AWS/ASME SFA - 5.13	~E FeMn-A
EN 14700	E Z Fe9
TS EN 14700	E Z Fe9
DIN 8555	~E 7-UM-200-KP

Properties and Applications

High recovery (120%), austenitic manganese steel electrode for hardfacing and joining of high manganese steels. Due to its excellent impact resistance, particularly suited for parts which are subjected to heavy impact, shock and cavitation. The addition of Ni and Cr alloys, increases the resistance against cracks and abrasion. Weld metal work hardens by cold-working. During welding, the workpieces should not become too hot and it shall be cool down, when necessary. High welding currents and wide-weave beads must be avoided. Machining is possible with tungsten carbide tipped tools. Suitable for hardfacing and repair welding of dredge pumps, hydraulic press pistons, crane wheels, rail crossings, crusher jaws, excavator and grab teeth, mill hammers, rock crusher.

Dayanım Gösterdiği Aşınma Tipleri ve Mikroyapısı

Abrasion	■				
Adhesion	■	■			
Darbe	■	■	■	■	■
Temperature	■				
Corrosion	■	■	■		

Typical Chemical Values of Weld Metal

Type of Analysis	C	Si	Mn	Cr	Ni	Fe
Weld Deposit	0.70	0.40	13.50	3.30	3.10	79.00

Typical Mechanical Values of Weld Metal

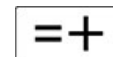
Test Condition	Hardness (HB)
As welded	225
After Cold Working	450

Application Information

Welding Positions



Polarity:



Welding Parameters & Efficiency

Diameter x Length (mm)	Current (A)
3.25x350	100-130
4.00x450	140-180

Packaging Information

Product Code	Diameter x Length (mm)	Quantity per Box	Box Gross Weight (kg)	Boxes per Outer Box	Outer Box Gross Weight (kg)	Packaging Type
18019NDEM2	3.25x350	70 pcs	2.64	3	8.10	Plastic Box
18019SFEM2	4.00x450	87 pcs	6.74	3	20.40	Plastic Box

Storage & Re-Drying Information

It can be dried maximum 5 times.
It should be stored in a dry room (relative humidity < 50%, room temperature > 20°C) on wooden pallets.
It has to be dried at 350°C for 2 hours.