EH 250

Covered Electrode for Hardfacing Applications -

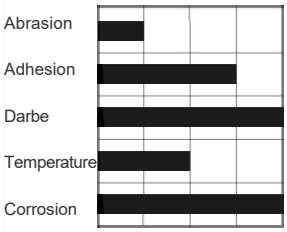
Standards

AWS/ASME SFA - 5.13	~EFeMnCr
EN 14700	E Z Fe9
TS EN 14700	E Z Fe9
DIN 8555	E 7-UM-250-KPR

Properties and Applications

High recovery (140%), austenitic manganese steel electrode for joining and hardfacing of high manganese steels which are subjected to very high pressure, shocks and abrasion. It is suitable to use as a buffer layer prior to hardfacing. Due to it is 12% Cr content, weld metal has high crack resistance and abrasion resistance with respect to other manganese steel electrodes. Weld metal work hardens by cold-working. Workpiece shall not become too hot during welding and when necessary, it shall be cool down before next hardfacing passes. High welding currents and wide-weave beads must be avoided. When welding large workpieces made of austenitic manganese steels, it is advisable to weld them in a water bath. Suitable for hardfacing and repair welding of dredge pumps, hydraulic press pistons, crane wheels, rail crossings, crusher parts subjected to impact of soft minerals.

Dayanım Gösterdiği Aşınma Tipleri ve Mikroyapısı



Typical Chemical Values of Weld Metal

Type of Analysis	C	Si	Mn	Cr
Weld Deposit	0,50	0.70	16.00	12.00

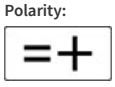
Typical Mechanical Values of Weld Metal

Test Condition	Hardness (HB)	Wear Index
As welded	230	71.75
After Cold Working	450	

Application Information

Welding Positions

Polarity:



Welding Parameters & Efficiency

Diameter x Length (mm)	Current (A)
3.25x350	100-140
4.00x450	150-200

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

18001NREM2	3.25x350	139 pcs	5.07	3	15.40	Cardboard Box
18001SSEM2	4.00x450	76 pcs	6.58	3	19.90	Cardboard 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.