

EH 330

Covered Electrode for Hardfacing Applications -

Standards

EN 14700	E Fe1
TS EN 14700	E Fe1
DIN 8555	E 1-UM-300-P

Approvals & Certificates

GOST

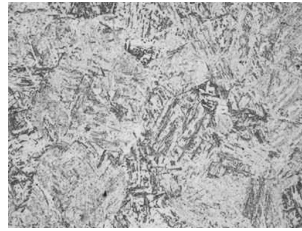
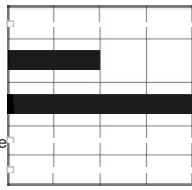
Properties and Applications

Thick basic-covered electrode for producing hardfacing deposits of medium hardness, which can be machined by chip-forming. Particularly suited for wear resisting parts subjected to metal-to-metal wear, heavy impact and shock. EH 330 can be easily welded in all positions, except vertical-down. Weld metal is crack resistant and free of pores. suitable for reconditioning of rails, rail crossings, switch points, sprockets and wearing parts, such as rope pulleys, tumblers, rollers, caterpillar track rollers and links, wheel flanges, stud links and others. DC, electrode in positive (+) is preferred and possible to use also in AC.

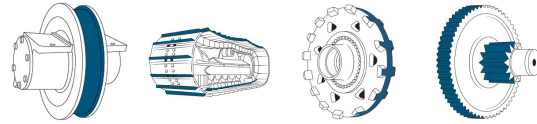


Dayanım Gösterdiği Aşınma Tipleri ve Mikroyapısı

Abrasion
Adhesion
Darbe
Temperature
Corrosion



Typical Applications



Typical Chemical Values of Weld Metal

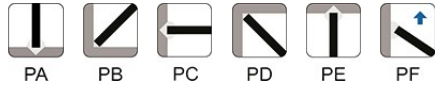
Type of Analysis	C	Si	Mn	Cr	Fe
Weld Deposit	0.05	0.80	0.65	3.40	95.10

Typical Mechanical Values of Weld Metal

Test Condition	Hardness (HB)	Wear Index
As welded	320	80

Application Information

Welding Positions



Polarity:



Welding Parameters & Efficiency

Diameter x Length (mm)	Current (A)	Weld Deposit(Kg)/1Kg Consumed Electrode	Number of Electrodes/1Kg Weld Deposit	Weld Metal Deposition Rate (Kg/h)
2.50x350	60-90	0,650	79	0,8
3.25x350	120-140	0,670	47	1,2
4.00x450	140-190	0,700	23	1,7
5.00x450	190-240			

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
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18003HREM2	2.50x350	256 pcs	5.07	3	15.40	Cardboard Box
18003NEEM2	3.25x350	155 pcs	5.21	3	15.80	Plastic Box
18003NREM2	3.25x350	155 pcs	5.07	3	15.40	Cardboard Box
18003SEEM2	4.00x450	104 pcs	6.74	3	20.40	Plastic Box
18003SSEM2	4.00x450	104 pcs	6.58	3	19.90	Cardboard Box
18003VSEM2	5.00x450	67 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.