

EH 340

Covered Electrode for Hardfacing Applications -

Standards

| | |
|-------------|--------------|
| EN 14700 | E Fe1 |
| TS EN 14700 | E Fe1 |
| DIN 8555 | E 1-UM-400-P |

Approvals & Certificates

GOST

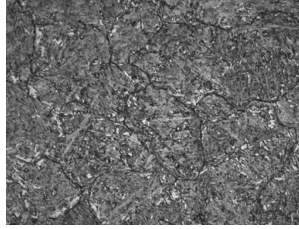
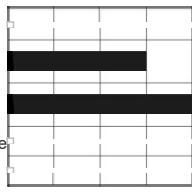
Properties and Applications

Thick basic-covered electrode for producing highly wear resisting hardfacing deposits. It is particularly resistant to metal-to-metal wear, impact and shock. Suitable for reconditioning of rails, rail crossings and switch points, wearing parts such as dredger parts, polygon edges, bearing surfaces, striking tools, die tyres, wheel flanges, slide surfaces subject to heavy wear, reconditioning of lower dies, punches and others. Weld metal can be machined only by using sintered hard metal tipped tools. Even a large number of layers can be deposited without the need of intermediate buffer layers. A tough buffer layer using ESB 40 or EI 307B electrodes is solely required in case of very crack sensitive base metal. EH 340 can be welded in all positions, except vertical-down. Preferred to use with DC, electrode in positive (+) pole and also possible to use with AC.



Dayanım Gösterdiği Aşınma Tipleri ve Mikroyapısı

Abrasion
Adhesion
Darbe
Temperature
Corrosion



Typical Applications



Typical Chemical Values of Weld Metal

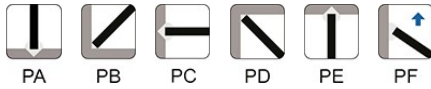
| Type of Analysis | C | Si | Mn | Cr | Fe |
|------------------|------|------|------|------|-------|
| Weld Deposit | 0.15 | 0.80 | 0.60 | 2.80 | 95.65 |

Typical Mechanical Values of Weld Metal

| Test Condition | Hardness (HRC) | Wear Index |
|----------------|----------------|------------|
| As welded | 42 | 63.14 |

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) |
|------------------------|-------------|---|---------------------------------------|-----------------------------------|
| 3.25x350 | 105-135 | 0,67 | 43 | 1,13 |
| 4.00x450 | 120-180 | 0,7 | 21 | 1,66 |
| 5.00x450 | 170-240 | 0,71 | 13 | 2,45 |

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 |
|--------------|------------------------|------------------|-----------------------|---------------------|-----------------------------|----------------|
| 18005NEEM2 | 3.25x350 | 151 pcs | 5.21 | 3 | 15.80 | Plastic Box |

| | | | | | | |
|------------|----------|---------|------|---|-------|---------------|
| 18005NREM2 | 3.25x350 | 151 pcs | 5.07 | 3 | 15.40 | Cardboard Box |
| 18005SEEM2 | 4.00x450 | 95 pcs | 6.74 | 3 | 20.40 | Plastic Box |
| 18005SSEM2 | 4.00x450 | 95 pcs | 6.58 | 3 | 19.90 | Cardboard Box |
| 18005VSEM2 | 5.00x450 | 60 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.