

EH 360R

Covered Electrode for Hardfacing Applications -

Standards

EN 14700	E Fe8
TS EN 14700	E Fe8
DIN 8555	E 6-UM-60-GPT

Approvals & Certificates

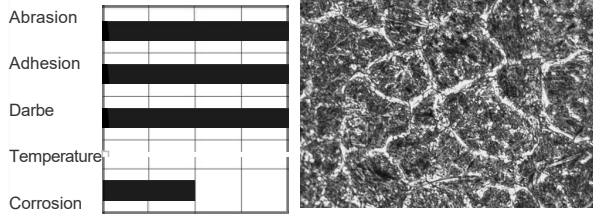
GOST

Properties and Applications

Thick rutile-covered electrode for depositing tough and wear resisting hardfacing overlays. It is particularly resistant to high metal-to-metal wear, moderate impact and abrasion. The weld metal has sufficient red hardness up to 600°C. It is machinable only by grinding. Suitable hardfacing applications where wear resistance at higher temperatures is a prime concern, as in hot cut offs, dies for pressure castings, rolls, crushers excavator parts, bucket edges and bucket teeth, drilling bits, coal planes, conveyor screws. In case of crack sensitive base metals, a tough buffer layer made by ESB 40 or EI 307B electrodes, is required and a further one after every third hardfacing layer. The as-welded hardness of 59 HRc can be increased to 60-65 HRc by single or double tempering. Possible to use equally well both with AC and DC.



Dayanım Gösterdiği Aşınma Tipleri ve Mikroyapısı



Typical Applications



Typical Chemical Values of Weld Metal

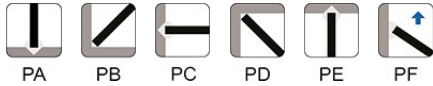
Type of Analysis	C	Si	Mn	Cr	V	Fe
Weld Deposit	0,50	0.65	0.60	9.00	0.40	88.85

Typical Mechanical Values of Weld Metal

Test Condition	Hardness (HRc)	Wear Index
As welded	58	68.92

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	0,49	100	0,63
3.25x350	100-140	0,5	60	0,68
4.00x450	140-180			
5.00x450	180-210	0,53	18	1,66

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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18007H9EM1	2.50x350	15 pcs	0.00	30	0.00	Blister
18007HDEM2	2.50x350	133 pcs	2.64	3	8.10	Plastic Box
18007HEEM2	2.50x350	266 pcs	5.21	3	15.80	Plastic Box
18007HREM2	2.50x350	266 pcs	5.07	3	15.40	Cardboard Box
18007N9EM1	3.25x350	10 pcs	0.38	25	9.70	Blister
18007NDEM2	3.25x350	73 pcs	2.64	3	8.10	Plastic Box
18007NEEM2	3.25x350	146 pcs	5.21	3	15.80	Plastic Box
18007NREM2	3.25x350	146 pcs	5.07	3	15.40	Cardboard Box
18007SBEM2	4.00x450	15 pcs	1.11	10	0.00	
18007SEEM2	4.00x450	99 pcs	6.74	3	20.40	Plastic Box
18007SSEM2	4.00x450	99 pcs	6.58	3	19.90	Cardboard Box
18007VEEM2	5.00x450	64 pcs	6.74	3	20.40	Plastic Box
18007VSEM2	5.00x450	64 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.
 Generally not required. If required, redry for 2 hour at 150°C.