

EH 360B

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

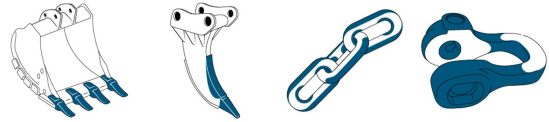
Thick basic-covered electrode for depositing tough and wear resisting overlays on structural members, subjected to severe wear. It is particularly resistant to high metal-to-metal wear, moderate impact and abrasion. The weld metal has sufficient red hardness up to 600°C. It can be machined only by grinding. 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. Multi-layers deposits will be free of cracks, even without depositing intermediate buffer layers. Only in case of very crack sensitive base metals, a tough buffer layer, made with ESB 40 or EI 307B electrodes, is required. 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

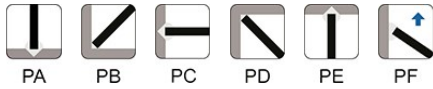
Type of Analysis	C	Si	Mn	Cr	Mo	V	Fe
Weld Deposit	0,50	0,80	0,60	8,00	0,50	0,65	88,95

Typical Mechanical Values of Weld Metal

Test Condition	Hardness (HRc)	Wear Index
As welded	59	62.34 (SiO ₂)

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	80-90	0,65	73	0,71
3.25x350	100-140			
4.00x350	140-180			
4.00x450	140-180	0,68	21	1,47
5.00x450	180-210	0,68	14	2,16

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
18006HDEM2	2.50x350	120 pcs	2.64	3	8.10	Plastic Box
18006HEEM2	2.50x350	241 pcs	5.21	3	15.80	Plastic Box
18006HREM2	2.50x350	241 pcs	5.07	3	15.40	Cardboard Box
18006NDEM2	3.25x350	71 pcs	2.64	3	8.10	Plastic Box
18006NEEM2	3.25x350	141 pcs	5.21	3	15.80	Plastic Box
18006NREM2	3.25x350	141 pcs	5.07	3	15.40	Cardboard Box
18006QEEM2	4.00x350	93 pcs	5.21	3	15.80	Plastic Box
18006QREM2	4.00x350	93 pcs	5.07	3	15.40	Cardboard Box
18006SEEM2	4.00x450	92 pcs	6.74	3	20.40	Plastic Box
18006SSEM2	4.00x450	92 pcs	6.58	3	19.90	Cardboard Box
18006VSEM2	5.00x450	61 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.