

EH 360Si

Covered Electrode for Hardfacing Applications -

Standards

TS EN 14700	E Z Fe2
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Properties and Applications

Thick basic-covered electrode for depositing wear resisting overlays on structural members subjected to severe abrasive wear. Weld metal can be machined only by grinding. Suitable for hardfacing applications of crushing and grinding of coal, mineral, soil, rocks, excavator parts, bucket edges and bucket teeth, drilling bits, coal planes, conveyor screws. In case of very crack sensitive base metals, a tough buffer layer, made with ESB 40 or EI 307B electrodes, is required, before hardfacing. Preferred to use with DC, electrode in positive (+) pole and also possible to use with AC.

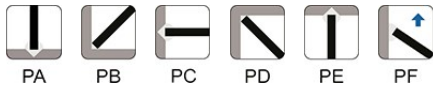


Typical Chemical Values of Weld Metal

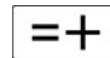
Type of Analysis	Fe
Weld Deposit	92.80

Application Information

Welding Positions



Polarity:



Welding Parameters & Efficiency

Diameter x Length (mm)	Current (A)
3.25x350	90-140
4.00x450	140-180
5.00x450	180-210

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
18018NREM2	3.25x350	148 pcs	5.07	3	15.40	Cardboard Box
18018SSEM2	4.00x450	96 pcs	6.74	3	20.40	Plastic Box
18018YSEM2	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.
It has to be dried at 350°C for 2 hours.