GRIDUR 6

TOP FEATURES

- Basic coated MMA hardfacing electrode with excellent impact and abrasion resistance
- Weld metal from a chromium–silicon hard alloy
- Achieves high hardness already in the first layer

TYPICAL APPLICATIONS

- Cold cutting knives
- Chisels, Scrape and rubbish, Wood working tools, Cutting edge repairs
- Earth moving and agricultural sliding components

CLASSIFICATION

EN 14700	E Fe6-60
DIN 8555	E 6-UM-60 GPS*

(*: Nearest classification)

CURRENT TYPE

AC; DC-

WELDING POSITIONS

All positions, except vertical down

CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, ALL WELD METAL

C	Mn	Cr	Si
0.5	0.3	9.5	3

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition	Hardness	
		(HRc)	(HV)
EN 14700	AW	57-62	
Typical values	AW	58	650

AW = As welded

Untreated weldmetal is only grindable

Heat treatment

Annealing 780 - 820°C / 5h

Hardening 1000 - 1050°C / oil or air

TYPICAL OPERATING PARAMETERS

Diameter x Length (mm)	Current range (A)
3.2 x 350	60-120
4.0 x 350	110-150

AVAILABLE SIZES AND PACKAGING INFORMATION

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
3.2 x 350	CBOX	139	4.2	98093235-2
4.0 x 350	CBOX	92	4.2	98094035-2