

# GRIDUR 61

## TOP FEATURES

- Metal to metal abrasion and heat resistant deposit with a martensitic structure containing special carbides
- Extremely wear resistant hardfacing, particularly suited for tool steels
- High resistance to heat and impact with excellent edge retention
- Low susceptibility to cracking; especially suitable for tool steels requiring extreme wear resistant hardfacing

## TYPICAL APPLICATIONS

- Punch & forming dies, shear blades, work rolls

## CLASSIFICATION

EN 14700 E Fe3-60  
DIN 8555 E 3-UM-60 T\*

(\*: Nearest classification)

## CURRENT TYPE

DC+; DC-; AC

## WELDING POSITIONS

All positions, except vertical down

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

C	W	Nb	Si	Ni	Cr	P	S	Fe
0.30	9.5	2.8	1.2	0.5	7.5	0.035	0.025	bal.

## MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition	Hardness (HRc)
EN 14700	AW	57-62
Typical values	AW	60

AW = As welded

## OPERATING CURRENT RANGE

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	125	4.7	98033235-2
4.0 x 350	CBOX	81	4.5	98034035-2