

SAFER R 600

TOP FEATURES

- Used for hardfacing carbon steels and low alloy steels against abrasion by mineral particles and medium impact and shock. Weld metal hardness ~550-650HV which can be ground. Very good resistance to moderate impacts.
- Preheating to 400°C is always necessary, particularly for large work pieces and deposit a maximum of 3 layers. When welding crack sensitive base materials a buffer layer is required using 307 type MMA electrode.
- Excellent weldability in all position except Vertical Down.

CLASSIFICATION

EN ISO 14700-A E Z (Fe2)

CURRENT TYPE

AC, DC-

WELDING POSITIONS

All position, except vertical down

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

C	Mn	Si	Cr	Fe
0.6	1.1	1	2.8	bal.

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Required	Condition*	Hardness (HRC)
EN ISO 14700	AW	30-58
Typical values	AW	52-57

*AW: As-welded

OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
3.2 x 450	85-125
4.0 x 450	100-150
5.0 x 450	150-210

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
3.2 x 450	CBOX	140	5.7	W000258791
4.0 x 450	CBOX	95	5.9	W000258792
5.0 x 450	CBOX	60	5.9	W000258793

TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application

Safety Data Sheets (SDS) are available here:



Subject to Change – The information is accurate to the best of our knowledge at the time of printing. Please refer to www.lincolnelectric.eu for any updated information.