SAFER R 600

MMA Electrodes

Hardfacing



SAFER R600 is a semi-thick basic coated MMA electrode which is easy to use.

Typical applications include hard facing subject to m abrasion, e,g civil works and mining equipment, shovel teeth, buckets and crawler shoes.

Used for hard facing carbon steels and low alloy steels against abrasion by mineral particles and medium impact and shock. Weld metal hardness $\sim 550-650$ HV 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 postion except Vertical Down. Shall be used in DC- or AC current.

Classif	ication		
EN ISO	14700: E Z (Fe2)		
DIN	8555: E 2-UM-60		

Chemical analysis (Typical values in %)

	C	Mn	Si	Cr	Fe
All weld metal	0.6	1.1	1	2.8	Rem

All-weld metal Mechanical Properties

Heat Treatment	Hardness		
As Welded	550-650 HV		

Materials

Surfacing of all wear parts when a specific rigidity in service is required as well as a high hardness level with good abrasion resistance under medium impacts.

Some applications: Civil works and mining equipment, mechanical shovels, buckets, crawler shoes, ...

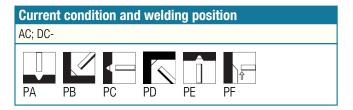
The SAFER R 400 electrode can be used as underlayer.

Storage

Keep dry and avoid condensation.

Re-drying not generally required.

If necessary: 100-150°C for 1 hour, 5 times max.



Packaging data

Diam.	Length	Current	Approx. weightn(kg/1000)	CBOX	
(mm)	(mm)	(A)		PC	Code
3.2	450	85-125	40.7	140	W000258791
4.0	450	100-150	61.6	95	W000258792
5.0	450	150-210	97.5	60	W000258793

