

# SAFER R 600

## MMA Electrodes

### Hardfacing

SAF-FRO

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 ~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. Shall be used in DC- or AC current.

#### Classification

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.

#### Current condition and welding position

AC; DC-



PA



PB



PC



PD



PE



PF

#### Packaging data

Diam. (mm)	Length (mm)	Current (A)	Approx. weightn(kg/1000)	CBOX	
				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