



CEWELD E DUR SS 60Ti

TYPE Hardfacing electrode for cutting edges and many overlay applications.

APPLICATIONS Developed for wear resistant overlays that faces high working temperatures and excellent for rebuilding cutting edges of knives and other cutting equipment.

PROPRIÉTÉS Outstanding alloy against abrasion, impact and high temperatures up-to 550 °C. The weld deposit of CEWELD DUR SS 60Ti is more or less comparable with HSS (High Speed Steel) and will offer outstanding welding properties on both AC and DC+ Recommended for manufacturing and reconditioning cutting tools.

CLASSIFICATION

AWS	A 5.13: ~E Fe6
EN ISO	14700: E Fe4
DIN	8555: E4-UM-60-ST
F-nr	71

CONVIENT POUR Cutting tools, Shear blades, Milling cutters, Drills, Hot work tools, wood knives etc. High speed Tool steel deposit.

AGRÉMENTS

POSITIONS DE SOUDAGE



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	Mo	V	Fe	W	Cr
0.9	0.4	1	8	1.5	Rem.	2	5

PROPRIÉTÉS MÉCANIQUES

Heat Treatment	R _{p0,2} (MPa)	R _m (MPa)	A ₅ (%)	Hardness
As Welded				60 HRc

ETUVAGE 300°C / 2 hr

HARDNESS 58 - 62 [HRC] Welded condition 63 - 65 [HRC] Tempered (530°C) 250 [HB] Soft annealed (810°C) 60 - 63 [HRC] Hardened at 1220°C

GAS ACC. EN ISO 14175



CEWELD E DUR SS 60Ti

E DUR SS 60Ti 2,5 X 350MM	Packaging	KG/unit	EanCode
	Can	2,4	8720663401724
E DUR SS 60Ti 3,2 X 350MM	Packaging	KG/unit	EanCode
	Can	2,5	8720663401731
E DUR SS 60Ti 4,0 X 350MM	Packaging	KG/unit	EanCode
	Can	2,5	8720663401748