

|                  |                |               |
|------------------|----------------|---------------|
| <b>Standards</b> | DIN 8555       | E 10-UM-60-GR |
|                  | DIN EN 14700   | E Fe14        |
|                  | AWS A5.13 / 21 | EFeCr-A1      |

**Approvals** ---

**Characteristics** CARBODUR 55 is a heavy coated high efficiency hardfacing electrode with 160 % recovery. Suitable for applications subject to strong abrasive wear by minerals, combined with moderate impact, medium shocks and compression as well as humidity or wetness. Soft fusion, fin-structured seam surface, self-releasing slag and a shiny surface of deposits

**Typical applications** mainly used on pump bodies, mixer blades, agitator arms, concrete pumps, conveyer worms, crushing and pulverizing plants, bucket teeth and coke-oven slides.

**Operating temperature**

|  |            |
|--|------------|
| <b>Hardness of all-weld metal</b><br>( typical values) | <b>HRc</b> |
|  | ca. 57     |

|  |          |           |           |               |
|--|----------|-----------|-----------|---------------|
| <b>Weld metal analysis</b><br>(typical, wt. %) | <b>C</b> | <b>Si</b> | <b>Cr</b> | <b>Others</b> |
|  | 4,5      | 1         | 28        | approx. 2     |

**Current** = + / ~ 50 V

**Welding positions** PA, PB

**Rebaking** 1 h, 350°C + / - 10 °C ( if required)

|                                   |             |
|-----------------------------------|-------------|
| <b>Flux-cored wire equivalent</b> | CARBO F- 55 |
|-----------------------------------|-------------|

| Dia./Length | Amperage (A) | Pcs./ packet | Pcs./ carton | kg / 1000 | kg / packet | kg / carton |
|-------------|--------------|--------------|--------------|-----------|-------------|-------------|
| 2.5 x 350   | 70 - 110     | 159          | 637          | 31.4      | 5.0         | 20.0        |
| 3.2 x 350   | 90 - 130     | 94           | 377          | 53.1      | 5.0         | 20.0        |
| 4.0 x 450   | 120 - 160    | 58           | 232          | 103.4     | 6.0         | 24.0        |
| 5.0 x 450   | 150 - 230    | 37           | 149          | 161.5     | 6.0         | 24.0        |
| 6.0 x 450   | 180 - 260    | 26           | 103          | 232.6     | 6.0         | 24.0        |

Rev. 001/12