

CARBODUR 59

| Standards | DIN 8555 | E 10-UM-60-GR |
|-----------|----------------|---------------|
| | AWS A5.13 / 21 | EFeCr-A1 |

Approvals

CARBODUR 59 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, and conveyer worms, crushing and pulverizing plants, bucket teeth and coke-oven slides.

Operating temperature

| Hardness of all-weld metal (typical values) | HRo ca. 5 | | | |
|--|--------------|-----|----|-----------|
| Weld metal analysis | С | Si | Cr | Others |
| (typical, wt. %) | 3,8 | 0,9 | 33 | approx. 2 |

Current $= + / \sim 50 \text{ V}$

Welding positions PA, PB

Rebaking

1 h, 350°C + / - 10 °C (if required)

| 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. 000

Statements on composition and application are just for the applier's information. Statements on mechanical properties always refer to the all-weld-metal according to valid standards. Carbo-Weld may change the characteristics of its products without notice. We recommend the applier to check our products for their special application autonomously.