

## **CARBODUR 61**

| Standards | DIN 8555     | E 10-UM-65-GTRZ |  |
|-----------|--------------|-----------------|--|
|           | DIN EN 14700 | E Fe16          |  |

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Approvals

Characteristics CARBODUR 61 is a heavy coated high efficiency hardfacing electrode with 240 % recovery. The weld metal has a ledeburitic structure with an alloy containing carbides of different kinds. CARBODUR 61 is used for hardfacing of parts subject to strong abrasive wear, friction, heat and corrosion. The weld metal is nearly free of slag. A buffer layer of CARBO 4370 MPR is recommended prior to surfacing on old claddings.

**Typical applications** Hardfacing on tools used in coal and ore mining as well as in the cement industry.

## Operating temperature

| Hardness<br>of all-weld metal<br>( typical values) | <b>HRc</b><br>ca. 64   |     |    |               |             |  |  |
|--|------------------------|-----|----|---------------|-------------|--|--|
| Weld metal analysis                                | С                      | Si  | Cr | Nb            | Others      |  |  |
| (typical, wt. %)                                   | 5,2                    | 2,2 | 29 | 6,8           | approx. 3,5 |  |  |
| Current  | = + / ~ 50 V           |     |    |               |             |  |  |
| Welding positions                                  | PA, PB                 |     |    |               |             |  |  |
| Rebaking   | 1 h, 150°C + / - 10 °C |     |    | (if required) |             |  |  |
| Flux-cored wire<br>equivalent                      | CARBO F- 61            |     |    |               |             |  |  |

| Dia./Length | Amperage (A) | Pcs./ packet | Pcs./ carton | kg / 1000 | kg / packet | kg / carton |
|-------------|--------------|--------------|--------------|-----------|-------------|-------------|
| 2,5 x 350   | 80 – 110     | 126          | 504          | 39,7      | 5.0         | 20.0        |
| 3,2 x 350   | 100 – 140    | 75           | 298          | 67,1      | 5.0         | 20.0        |
| 4,0 x 450   | 130 – 180    | 46           | 184          | 130,7     | 6.0         | 24.0        |
| 5,0 x 450   | 170 – 240    | 29           | 117          | 204,3     | 6.0         | 24.0        |

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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.