

<b>Standards</b>	DIN 8555	E 10-UM-70-GTRZ
	DIN EN 14700	E Fe15
	AWS A5.13 / 21	EFeCr-A1

**Approvals** ---

**Characteristics** Thickly coated high efficiency electrode with approx. 240 % recovery. The weld metal structure is ledeburitic, the alloy contains carbide forming elements of different kinds. CARBODUR 68 is mainly used for applications where parts are subject to strong abrasive wear since the deposited alloy is highly resistant to abrasion, also when exposed to high temperatures. Smooth fusion, almost slag-free deposit. Prior to surfacing on old hardfacing layers a buffer layer with CARBO 4370 MPR is recommended.

**Operating temperature** From room temperature up to 800° C

**Typical applications** CARBODUR 68 is mainly used for hardfacing on equipment in sintering plants, steel mills, coke oven plants, coal excavation and overburden removal, etc.

**Hardness** 68 – 70 HRC already in the first layer

<b>Mechanical properties of all-weld metal</b>  (typical values)	<b>Hardness HRC</b>	<b>Hardness HRC at 600° C</b>	<b>Hardness HRC at 800° C</b>
	approx. 69	approx. 64	approx. 58

<b>Weld metal analysis</b> (typical, wt. %)	<b>C</b>	<b>Si</b>	<b>Cr</b>	<b>Others</b>
	5,5	2	35	ca. 4

**Current** = +/- ~ 50 V

**Welding positions** PA, PB

**Rebaking** 1 h, 150 °C +/- 10 °C ( if required )

**Flux-cored wire equivalent** CARBO F- 68

Dia./Length	Amperage (A)	Pcs./ packet	Pcs./ carton	kg / 1000	kg / packet	kg / carton
2.5 x 350	80 – 110	148	592	33,8	5.0	20,0
3.2 x 450	110 – 140	88	350	57,1	6.0	20,0
4.0 x 450	140 – 180	54	216	111,1	6.0	24,0
5.0 x 450	180 – 230	35	138	173,6	6.0	24,0

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