

CARBODUR 437 T

Standards	DIN 855	55		E 10-GF-	UM-60-G	R	
Approvals							
Characteristics	Tubular electrode filled with chromium carbide powder, suitable for hardfacing on parts which are mainly subject to abrasive wear, but also to impact stress. High amount of Cr carbides in an austenitic matrix, very compact. Due to its special metallurgical composition, this electrode can be consumed with very low current. High hardness is achieved already in the first layer. Soft, quiet fusion. The weld metal is almost free of slag. A buffer layer of CARBO 4370 MPR is recommended prior to surfacing on old claddings.						
Operating temperature							
Typical applications	Mainly used for hardfacing on pump bodies, mixer blades, agitator arms, concrete pumps, conveyer worms, and coke-oven slides, and agricultural machines, in civil engineering and in the cement industry.						
Hardness of all-weld metal	HR	C					
(typical values)	62-6	64					
Weld metal analysis	С	Mn	Cr	Мо	Nb]	
(typical, wt. %)	5.5	0,8	26	0,85	6,2		
Current	= + / ~ 50 V						
Welding positions	PA, PB						
Rebaking	1 h, 150°C + / - 10 °C (if required)						
Dia /Length Amperage (A) Pcs / packet Pcs / carton kg / 1000 kg / packet kg / carton							

80 - 110 67 268 74.6 5.0	20.0
20 - 140 38 152 131.6 5.0	20.0
40 - 180 22 88 227.3 5.0	20.0

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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.