

Classifications

EN 14700	DIN 8555
E Fe8	E 3-UM-55-ST

Characteristics and typical fields of application

WEARstick Tool 55 is, due to its high hardness, toughness and heat-resistance ideally suited for build-ups on parts subject to severe friction, compression and moderate impact loads at elevated temperatures, such as back centers, gripping pliers, gliding and guiding surfaces, hot and cold punching tools, valves, slides, hot-shear blades, extrusion press pistons, forging tools, stripping columns, trimming tools, roll mandrils or punching tools for sheet metals. WEARstick Tool 55 is used to good advantage for the production of new cold and hot working tools. In such cases cladding is made on base material with an accordingly high tensile strength.

The stick electrode has excellent welding properties, a stable and regular flow, good bead appearance and very easy slag removal. Heat-resistant up to 550 °C.

Hardness of the pure weld metal: 55 - 58 HRC

Typical analysis

	C	Si	Mn	Cr	Mo	Fe
wt.-%	0.35	0.5	1.3	7.0	2.5	Bal.

Operating data

	Polarity	DC + / AC	Dimension mm	Current A
	Redrying	300°C / 2h		2.5 × 300
			3.2 × 350	80 – 110
			4.0 × 400	100 – 140
			5.0 × 400	130 – 170

Welding instructions

Preheat the workpiece to 400 °C. Hold stick electrode as vertically as possible and with a short arc. Allow the workpiece to cool down slowly. Finish by grinding.

Approvals

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