

Classifications

AWS A5.13 / SFA-5.13	DIN 8555	EN 14700
EFeCr-A8 (mod.)	E 10-UM-60-GRZ	E Fe14

Characteristics and typical fields of application

WEARstick XD 61 is suited for highly wear resistant claddings on parts subject to strong grinding abrasion combined with medium impact, such as conveyor screws, scraper blades, bucket teeth, mixer wings, sand pumps. Also as a final layer on crusher jaws.

WEARstick XD 61 has excellent welding characteristics and a very easy slag removal. The homogeneous and finely rippled seam surface does, for most applications, not require any finishing by grinding.

Hardness of the pure weld deposit: approx. 60 HRC


1 layer on steel with C = 0,15 %: approx. 55 HRC

1 layer on high Mn-steel: approx. 52 HRC

Typical analysis

	C	Si	Cr	Fe
wt.-%	3.2	1.3	32.0	bal.

Operating data

	Polarity	DC + / AC	Dimension mm	Current A
	Redrying	2h / 300° C	2.5 × 350	80 – 100
			3.2 × 350	90 – 130
			4.0 × 450	130 – 180
			5.0 × 450	140 – 190

Welding instructions

Hold stick electrode as vertically as possible, keep a short arc. For multipass applications a cushion layer with UTP 630 is recommended. Redry stick electrodes that have got damp for 2h / 300 °C.

Approvals

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