

## Classifications

<b>DIN 8555</b>	<b>EN 14700</b>
E 10-UM-65-GR	E Z Fe 15

## Characteristics and typical fields of application

WEARstick XD 63 is used for hardfacing of parts subject to heavy abrasion with moderate impact, i.e. cement presses, brick presses, refractory press-screws, conveyor screws, mixer blades, palm-nut etc.

Service temperature up to 450 °C.

WEARstick XD 63 has a quiet and regular drop transfer, can be welded in flat and vertical-up position. 190 % recovery. Stable arc, easy slag removal. Machining by grinding only.

Hardness of the pure weld deposit:

1. layer: 62 HRC
2. layer: 63 HRC

## Typical analysis

	C	Si	Mn	Cr	Nb	Fe
wt.-%	6.5	1.5	1.5	24.5	7.0	bal.

## Operating data

	<b>Polarity</b>	<b>DC + / AC</b>	<b>Dimension mm</b>	<b>Current A</b>	
	<b>Redrying</b>	1 h / 300°C		3.2 × 350	110 - 140
				4.0 × 450	140 - 190
			5.0 × 450	190 - 250	

Hold the electrode vertically and keep a short arc, prepare the welding zone by polishing to metallic blank. For multi-layers, a buffer layer with UTP 630 is recommended. Re-drying: 1 hour at 300 °C.

## Approvals

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