

Classifications

DIN 8555	DIN EN 14700
E 10-UM-65-GRZ	E Fe16

Characteristics and typical fields of application

WEARstick XD 65 is suited for highly abrasion resistant claddings on parts subject to extreme sliding mineral abrasion, also at elevated temperatures up to 500 °C. The extremely high abrasion resistance is reached by the very high content of special carbides (Mo, V, W, Nb). Main application fields are surfacings on earth moving equipment, working parts in the cement and brick industry as well as in steel mills for radial breakers und revolving-bar screens of sintering plants.

WEARstick XD 65 has an even droplet transfer in the spray arc. The smooth welding bead is without slag covering. In general there is no need for any finishing by grinding.

Recovery approx. 265 %

Hardness of the pure weld deposit: approx. 65 HRC

1 layer on steel with C = 0.15 %: approx. 58 HRC

1 layer on high Mn-steel: approx. 55 HRC

Typical analysis

	C	Cr	Mo	W	V	Nb	Fe
wt.-%	4.5	23.5	6.5	2.2	1.5	5.5	bal.

Operating data

	Polarity	DC+ / AC	Dimension mm	Current A
	Redrying	2h / 300°C	3.2 × 350	110 – 150
			4.0 × 450	140 – 200
			5.0 × 450	190 – 250

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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