

ArcTrode® | HF 600 B

Hardfacing **ELECTRODE/ SMAW**

Standards

DIN-Standard - 8555

DIN-Classification - E6-UM-60P

Features and Applications

- Basic coated low hydrogen hardfacing electrode for depositing tough wear resisting overlays.
- Ideal for application subject to hard impact and abrasion on unalloyed and low-alloyed materials.
- A tough buffer layer is recommended for crack sensitive base metals.
- Suitable for low open circuit voltage transformers (min. OCV 70V).
- Typical applications include hardfacing excavator parts, bucket edges, bucket teeth, drilling bits, coal planes, conveyor screws, polygon edges, crusher jaws, cones etc.
- Re-drying if necessary 300-350°C for 2 hours.
- **Test Certificates can be found online @wilkinsonstar247.com**



Welding Positions

EN ISO 6947 - PA, PB, PC, PF

Polarity

AC; DC (+)

Welding Parameters

Ø mm	3.20	4.00	5.00
Current (A)	100-140	140-180	190-240

Mechanical Properties

Hardness (HRC)
57-61

Mechanical properties are approximate and may vary based on the heat, welding parameters and other factors.

Analysis of all-weld metal % (Typical)

C %	Si %	Mn %	Cr %	Fe %
0.50	1.00	1.00	7.00	rem.

Packaging Data

Part No.	Diameter x Length Ø (mm)	Packet Weight (Kg)	Electrode Pieces Per/Packet	Carton Weight (Kg)
8011100389	3.20 x 350	5	~146	15
8011100392	4.00 x 350	5	~92	15
8011100395	5.00 x 350	5	~61	15

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