

# CEWELD E DUR SS 60Ti

|                |                                                                                                                                                                                                                                                                                                               |                                                           |  |
|----------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------|--|
| TYPE           | Hardfacing electrode for cutting edges and many overlay applications.                                                                                                                                                                                                                                         |                                                           |  |
| APPLICATIONS   | Developed for wear resistant overlays that faces high working temperatures and excellent for rebuilding cutting edges of knives and other cutting equipment.                                                                                                                                                  |                                                           |  |
| PROPRIÉTÉS     | Outstanding alloy against abrasion, impact and high temperatures up-to 550 °C. The weld deposit of CEWELD DUR SS 60Ti is more or less comparable with HSS (High Speed Steel) and will offer outstanding welding properties on both AC and DC+ Recommended for manufacturing and reconditioning cutting tools. |                                                           |  |
| CLASSIFICATION | AWS<br>EN ISO<br>DIN<br>F-nr                                                                                                                                                                                                                                                                                  | A 5.13: ~E Fe6<br>14700: E Fe4<br>8555: E4-UM-60-ST<br>71 |  |
| CONVIENT POUR  | Cutting tools, Shear blades, Milling cutters, Drills, Hot work tools, wood knives etc. High speed Tool steel deposit.                                                                                                                                                                                         |                                                           |  |

## AGRÉMENTS

## POSITIONS DE SOUDAGE



## ANALYSE CHIMIQUE TYPIQUE DU MÉTAL DE SOUDURE (%)

| C   | Si  | Mn | Mo | V   | Fe   | W | Cr |
|-----|-----|----|----|-----|------|---|----|
| 0.9 | 0.4 | 1  | 8  | 1.5 | Rem. | 2 | 5  |

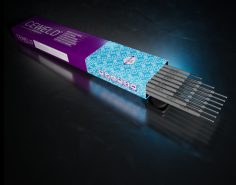
## PROPRIÉTÉS MÉCANIQUES

| Heat Treatment | R <sub>p0.2</sub> (MPa) | R <sub>m</sub> (MPa) | A5 (%) | Hardness |
|----------------|-------------------------|----------------------|--------|----------|
| As Welded      |                         |                      |        | 60 HRc   |

ETUVAGE 300°C / 2 hr

HARDNESS 58 - 62 [HRC] Welded condition 63 - 65 [HRC] Tempered (530°C) 250 [HB] Soft annealed (810°C) 60 - 63 [HRC] Hardened at 1220°C

GAS ACC. EN ISO 14175



# CEWELD E DUR SS 60Ti

|                           |           |         |               |
|---------------------------|-----------|---------|---------------|
| E DUR SS 60Ti 2,5 X 350MM | Packaging | KG/unit | EanCode       |
|                           | Can       | 2,4     | 8720663401724 |
| E DUR SS 60Ti 3,2 X 350MM | Packaging | KG/unit | EanCode       |
|                           | Can       | 2,5     | 8720663401731 |
| E DUR SS 60Ti 4,0 X 350MM | Packaging | KG/unit | EanCode       |
|                           | Can       | 2,5     | 8720663401748 |