

EH 360B

Standards

EN 14700	E Fe8
TS EN 14700	E Fe8
DIN 8555	E 6-UM-60 GPT

Approvals & Certificates

GOST

Covered Electrode for Hardfacing Applications -

Properties and Applications

Thick basic-covered electrode for depositing tough and wear resisting overlays on structural members subjected to severe wear. It is particularly resistant to high meta-to-metal wear, moderate impact and abrasion. The weld metal has sufficient red hardness up to +600°C. It can be machined only by grinding. Suitable hardfacing applications where wear resistance at higher temperatures is a prime concern, as in hot cut offs, dies for pressure castings, rolls, crushers excavator parts, bucket edges and bucket teeth, drilling bits, coal planes, conveyor screws. Multi-layers deposits will be free of cracks, even without depositing intermediate buffer layers. Only in case of very crack sensitive base metals, a tough buffer layer, made with ESB 40 or EI 307B electrodes, is required. Preferred to use with DC, electrode in positive (+) pole and also possible to use with AC.



Dayanım Gösterdiği Aşınma Tipleri ve Mikroyapısı

Property	1	2	3	4	5
Abrasion					
Adhesion					
Darbe					
Temperature					
Corrosion					

Typical Applications



Typical Chemical Values of Weld Metal

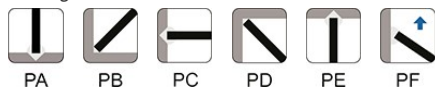
Type of Analysis	C	Si	Mn	Cr	Mo	V	Fe
Weld Deposit	0.5	0.8	0.6	8	0.5	0.65	Rest

Typical Mechanical Values of Weld Metal

Test Condition	Hardness (HRc)	Wear Index
As welded	59	62.34 (SiO2)

Application Information

Welding Positions



Polarity:



Welding Parameters & Efficiency

Diameter x Length (mm)	Current (A)	Kg Kaynak Metali/1Kg Elektrod	Elektrod Adedi/1Kg Kaynak Metali	Weld Metal Deposition Rate (Kg/h)
2.50x350	80-90	0,65	73	0,71
3.25x350	100-140	0,65	43	1,01
4.00x350	140-180	0,65	28	1,37
4.00x450	140-180	0,68	21	1,47
5.00x450	180-210			

Packaging Information

Product Code	Diameter x Length (mm)	Quantity per Box	Box Gross Weight (Kg)	Boxes per Outer Box	Outer Box Gross Weight (Kg)	Packaging Type
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18006HDEM2	2.50x350	120 AD	2.64	3	8.10	Plastic Box
18006HEEM2	2.50x350	241 AD	5.21	3	15.80	Plastic Box
18006HREM2	2.50x350	241 AD	5.07	3	15.40	Cardboard Box
18006NDEM2	3.25x350	71 AD	2.64	3	8.10	Plastic Box
18006NEEM2	3.25x350	141 AD	5.21	3	15.80	Plastic Box
18006NREM2	3.25x350	141 AD	5.07	3	15.40	Cardboard Box
18006QEEM2	4.00x350	93 AD	5.21	3	15.80	Plastic Box
18006QREM2	4.00x350	93 AD	5.07	3	15.40	Cardboard Box
18006SEEM2	4.00x450	92 AD	6.74	3	20.40	Plastic Box
18006SSEM2	4.00x450	92 AD	6.58	3	19.90	Cardboard Box
18006VSEM2	5.00x450	61 AD	6.58	3	19.90	Cardboard Box

Storage & Re-Drying Information

It can be dried maximum 5 times.
 It should be stored in a dry room (relative humidity < 50%, room temperature > 20°C) on wooden pallets.
 It has to be dried at 350°C for 2 hours.