

EH 360R

Covered Electrode for Hardfacing Applications -

Standards

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

Approvals & Certificates

GOST

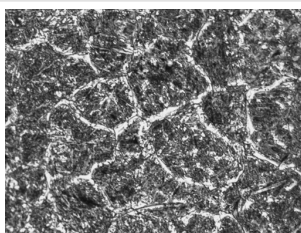
Properties and Applications

Thick rutile-covered electrode for depositing tough and wear resisting hardfacing overlays. 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 is machinable 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. In case of crack sensitive base metals, a tough buffer layer made by ESB 40 or EI 307B electrodes, is required and a further one after every third hardfacing layer. The as-welded hardness of 59 HRc can be increased to 60-65 HRc by single or double tempering. Possible to use equally well both with AC and DC.



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

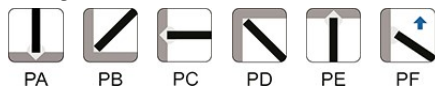
Type of Analysis	C	Si	Mn	Cr	V	Fe
Weld Deposit	0.50	0.65	0.6	9	0.4	Rest

Typical Mechanical Values of Weld Metal

Test Condition	Hardness (HRc)	Wear Index
As welded	58	68.92

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	60-90	0,49	100	0,63
3.25x350	100-140	0,5	60	0,68
4.00x450	140-180	0,56	27	1,24
5.00x450	180-210	0,53	18	1,66

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
18007HDEM2	2.50x350	133 AD	2.64	3	8.10	Plastic Box

18007HEEM2	2.50x350	266 AD	5.21	3	15.80	Plastic Box
18007HREM2	2.50x350	266 AD	5.07	3	15.40	Cardboard Box
18007N9EM1	3.25x350	10 AD	0.38	25	9.70	Blister
18007NDEM2	3.25x350	73 AD	2.64	3	8.10	Plastic Box
18007NEEM2	3.25x350	146 AD	5.21	3	15.80	Plastic Box
18007NREM2	3.25x350	146 AD	5.07	3	15.40	Cardboard Box
18007SEEM2	4.00x450	99 AD	6.74	3	20.40	Plastic Box
18007SSEM2	4.00x450	99 AD	6.58	3	19.90	Cardboard Box
18007VEEM2	5.00x450	64 AD	6.74	3	20.40	Plastic Box
18007VSEM2	5.00x450	64 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.
 Generally not required. If required, redry for 2 hour at 150°C.