



EH 806

Covered Electrode for Hardfacing Applications -

Standards	
AWS/ASME SFA - 5.13	ECoCr-A
EN 14700	E Co2
TS EN 14700	E Co2

Properties and Applications

Rutile-basic type coated hardfacing electrode which deposits Co-Cr-W alloy weld metal. Suitable to use in hardfacing of parts subjected to either the single or combined effect of : heavy metal-to-metal wear or abrasion, high temperatures (ranging from 500°C to 900°C) and corrosive environments. Due to its very higher toughness and shock resistance extends its use for service conditions involving mechanical impacts and thermal shocks. Suitable for blades for hot shearing, ingot tong ends, glass moulds, valves and valve seats, nozzles. Preferred to use with DC, electrode in positive (+) and possible to use with also AC.




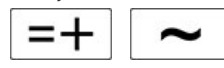
Typical Chemical Values of Weld Metal

Type of Analysis	C	Si	Mn	Cr	W	Co
Weld Deposit	1	1	1	27	5	Rest

Typical Mechanical Values of Weld Metal

Test Condition	Hardness (HRc)
As welded	43

Application Information

Welding Positions  PA PB	Polarity: 						
Welding Parameters & Efficiency							
<table border="1"> <thead> <tr> <th>Diameter x Length (mm)</th> <th>Current (A)</th> </tr> </thead> <tbody> <tr> <td>3.25x350</td> <td>80-120</td> </tr> <tr> <td>4.00x350</td> <td>110-150</td> </tr> </tbody> </table>	Diameter x Length (mm)	Current (A)	3.25x350	80-120	4.00x350	110-150	
Diameter x Length (mm)	Current (A)						
3.25x350	80-120						
4.00x350	110-150						

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
18016NDEM2	3.25x350	65 AD	2.64	3	8.10	Plastic Box
18016NEEM2	3.25x350	130 AD	5.21	3	15.80	Plastic Box
18016QDEM2	4.00x350	45 AD	2.64	3	8.10	Plastic Box
18016QEEM2	4.00x350	90 AD	5.21	3	15.80	Plastic 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 150°C for 1 hour.



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