

Prepared by David P	Qualified by Siva P	Approved by Umesh M	Reg no EN2020051	Cancelling EN2020050	Reg date 2024-08-15	Page 1 (2)
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GENERAL

Iron-based SMAW electrode to deposit alloy with good impact and frictional wear resistance. This alloy possesses excellent cushioning properties, high compressive strength and good anti-spalling properties. The deposit is dense, magnetic and readily machinable with cutting tools. High toughness and deformation resistance of this alloy makes it ideal for multi-layer build-up on all ferrous alloys and the deposit is capable of withstanding heavy shock loading and pounding in service. For rebuilding and reclamation of chain guide rolls, worn parts on bulldozers, rebuilding of large, severely worn parts.

Polarity: DCEP

Alloy Type : Fe based alloy

Coating Type : Basic

WELDING POSITIONS



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CLASSIFICATIONS Electrode

EN 14700 : TFe1

DIN 8555 : MF1-GF-300-P

APPROVALS

CHEMICAL COMPOSITION

All Weld Metal (%)

	Min	Max	Nom
C	0.05	0.2	0.1
Si	0.5	1.0	0.8
Mn	0.5	1.5	1.1
Cr	0.2	1.0	0.5
Mo	0.1	0.8	0.3
Fe	-	-	Balance

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MECHANICAL PROPERTIES OF WELD METAL

Hardness	Min	Max	Nom
As-deposited hardness	25 HRc	35 HRc	30 HRc

Comments:

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ECONOMICS & CURRENT DATA

Wire Dia (mm)	Voltage (V)	Current (A)	Stick-out (mm)
1.60	24-28	16-300	35 - 45

OTHER DATA

Clean weld area. Use EWAC GOUGETEC to remove fatigued or damaged metal. Pre-heat heavy section to 200 - 250 °C. Use stringer or weaving technique. Do not allow excessive heat build-up. Chip slag between passes. Allow to cool slowly. PHWT can be performed if required.

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