



CEWELD E DUR SS 60Ti

TYPE Very thick rutile-coated high-performance electrode for overlay welding on tool and high-speed steels.(E Fe4, 1.3346)

APPLICATIONS CEWELD® E DUR SS 60Ti is developed for wear resistant overlays that faces high working temperatures and excellent for rebuilding cutting edges of knives and other cutting equipment. For cutting tools such as:
Hot block and billet shears, slitting, cutting, punching, forging, pressing and drawing tools, pressing and drawing tools.

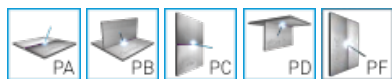
PROPERTIES CEWELD® E DUR SS 60Ti have a outstanding CrMoVW-alloy against abrasion, impact and high temperatures up-to 550 °C. The weld deposit of CEWELD® E DUR SS 60Ti is more or less comparable with HSS (High Speed Steel) and will offer outstanding welding properties on both AC and DC+
58 - 62 [HRC] Welded condition
63 - 65 [HRC] Tempered (530°C)
250 [HB] Soft annealed (810°C)
60 - 63 [HRC] Hardened at 1220°C

CLASSIFICATION AWS A 5.13: ~E Fe6
EN ISO 14700: E Fe4
DIN 8555: E4-UM-60-ST
F-nr 71

SUITABLE FOR Cutting tools, Shear blades, Milling cutters, Drills, Hot work tools, wood knives etc. High speed Tool steel deposit.

APPROVALS

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

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

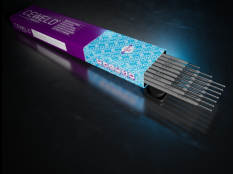
MECHANICAL PROPERTIES

Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A5 (%)	Hardness
As Welded				60 HRc

REDRYING 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