



CEWELD E DUR 63 Nb

TYPE Basic coated, high Chromium-Niobium based Hardfacing alloy for SMAW

APPLICATIONS This electrode with a recovery of 190% can be used for overlays with extremely abrasive and sliding wear resistance, but with low impact. For use till 450 °C.

PROPRIÉTÉS Very economical due to the high deposition rate and excellent weldability without slag losses. For critical base material or old hard facing layers it is necessary to buffer with an electrode like CEWELD E DUR 350 Kb / E 11018-G that delivers a welding deposit of less hardness. Overlays on steel with high carbon content should be buffered with CroNi 29/9 HL or 4370 HL. For the best results 2 till 3 layers should be welded.

CLASSIFICATION

AWS	A 5.13: ~E FeCr-E4
EN ISO	14700: E Fe15
DIN	8555: E 10-UM-65- GRZ
F-nr	71

CONVIENT POUR Sugar mill knives and Hammers, Cement mixers, Clinker crushers, Sintering lines, Fire gratings, Mixer blades, Gravel washing equipment, Ceramic mixer blades, Extruders, Crushing tables and Rollers for lime stone etc.

AGRÉMENTS

POSITIONS DE SOUDAGE



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Cr	Nb	Fe
5.75	24	6	Rem.

PROPRIÉTÉS MÉCANIQUES

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

ETUVAGE 300°C / 2 hr

GAS ACC. EN ISO 14175



CEWELD E DUR 63 Nb

E DUR 63 NB 3,2 X 350MM

Packaging	KG/unit	EanCode
Can	2,5	8720663402653

E DUR 63 NB 4,0 X 450MM

Packaging	KG/unit	EanCode
Can	3	8720663402660