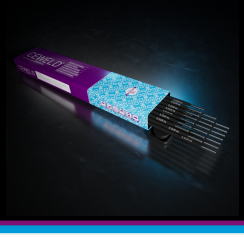


CEWELD E DUR 64

certilas® THE FILLER METAL SPECIALIST

TYPE

Basic coated, high Chromium-Niobium based Hardfacing high recovery hardfacing electrode

APPLICATIONS

This electrode with a recovery of 190% can be used for overlays with extremely abrasive and sliding wear resistance, but with middle impact.

PROPERTIES

Due to the high Mo-content, abrasion resistance can be kept up to working temperatures of 600 °C ; the hardness is still 40-45 HRc at these temperatures. For Hardfacing of more than 3 layers it is necessary to buffer with an electrode like CEWELD® E DUR 350 Kb that delivers a welding deposit of less hardness. Overlays on steel with high tensile strength have to be buffered with CroNi 29/9 HL or 4370 HL. Equivalent in FCAW: CEWELD® OA 64

CLASSIFICATION

AWS	A 5.13: E FeCr-E4
EN ISO	14700: E Fe16
DIN	8555: E 10-UM-65- GTZ
F-nr	71

SUITABLE FOR

Sugar mill knives and Hammers, Clinker crushers, Sintering lines, Fire gratings, Mixer blades, Gravel washing equipment, Ceramic mixer blades, Mill rollers, Stone crushers, Cxtruders etc....

APPROVALS

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Mn	Cr	Mo	Nb	V	Fe	W	Si
5.5	0.6	24	6	6	1	Rem.	2	0.9

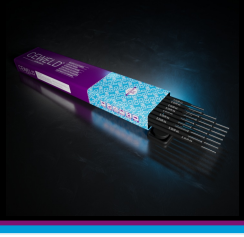
MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Hardness
As Welded				61 HRc

REDRYING

300°C / 2 hr

GAS ACC. EN ISO 14175



CEWELD E DUR 64

certilas® THE FILLER METAL SPECIALIST

E DUR 64 3,2 X 350MM

Packaging	KG/unit	EanCode
Can	2,4	8720663402677

E DUR 64 4,0 X 450MM

Packaging	KG/unit	EanCode
Can	3,0	8720663402684

E DUR 64 5,0 X 450MM

Packaging	KG/unit	EanCode
Can	2,9	8720663402691