

## Key Facts

- Provides high toughness in spite of high hardness and excellent abrasion resistance to medium impact.
- Extends the operation life of many wearing parts
- Excellent abrasion resistance to medium impact
- Deposits weld metal of high toughness
- Hard facing electrode 52HRC single layer, 55HRC multiple layers

## Description

A rutile coated, hard facing electrode featuring deposits of high toughness and excellent abrasion resistance to medium impact. Positions: flat, horizontal and vertical-up.

## Classification

DIN 8555 E 6-UM-55

## Welding Positions

Flat, horizontal and vertical up.

## Markings & Identification

End tip Colour: Grey  
 End side Colour: Orange  
 Printing: GEMINI H600 R

## Applications

Suitable for surfacing worn parts of civil engineering, construction and mining equipment, without machining. Applications include guillotine blades, punches, dies, pneumatic drills and chisels, axes, ripper teeth, wood chipper anvils and blades and debarking hammers.



## Typical All Weld Metal Analysis

C - Carbon	Mn - Manganese	Si - Silicon
0.50%	1.00%	0.80%
Cr - Chromium		
7.00%		

## Typical All Weld Metal Mechanical Properties

Single Layer:	52 HRC
Multiple Layer:	55 HRC

## Packaging & Ordering Information

Size	Packet	Ctn	Current Range	Part Number
3.2mm	5kg	20kg	85-140	100186
3.2mm	6stk	10pkt	85-140	100186H
4.0mm	5kg	20kg	100-170	100187

Disclaimer: The above information is provided as a guide; actual welding current and voltage will depend on the welding machine characteristics, which will vary from model to model. Other variables include run length and size, plate thickness, operator technique and gas type (if used). The user must evaluate the process, application and recommended professional advice. Under no circumstance will Dynaweld or its affiliates be liable for misuse or application of products this is entirely up to the user's ability.