Product Data Sheet

Hardfacing electrode resistant to Impact, compression and abrasion

STAVINOX 55RC

Classification ***DIN* 8555:** E6-UM-60P

Description And Applications Hard surfacing electrode for tough - hard, impact tough And abrasive resistant surfacing on unalloyed and low alloyed materials with higher tensile strength. Recommended For surfacing on machine parts, dredge teeth, beater bars, conveyor worms, mill hammers, mixer arms, crusher jaws, cones……

All Weld Metal Mechanical Properties

Hardness
57- 61 HRC

Obtained in pure weld metal

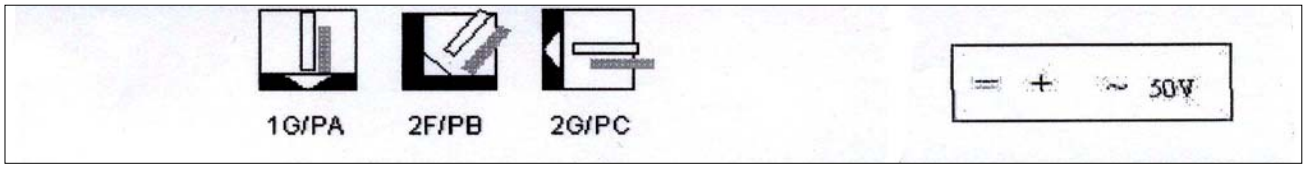
Typical weld metal Composition (%)

C	Si	Mn	Cr	V	Mo	Fe
0.56	0.41	0.62	7.00	0.60	0.70	Rem

Welding Current

3.15	4.00	5.00
90- 120	140- 180	180- 230

Welding instruction Guide electrode with a short arc. On materials sensitive to cracks use a buffer-layer of 18/8Mn type is recommended. Low alloyed, high carbon tool steels etc, have to be preheated to 200-400°C, depending on their composition and thickness. Slow cooling in still air after surfacing.



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