

<b>International standards</b>	DIN 8555	E 7-UM-250-KP
	DIN EN 14700	E Fe9
	AWS A56.13	E FeMn-A

**Approvals** ---

**Characteristics** Basic coated, AC-weldable electrode with approximately 120 % recovery. Due to the weld metal's high tenacity and hardness, CARBODUR Mn is suitable for hardfacing on parts which are subject to extreme impact stress and cavitation. A considerable increase in wear resistance through strain hardening can be achieved by cold-hammering.

**Operating temperature** ---

**Typical applications** Excavator teeth, crushing hammers, rings in rotary furnaces, rail switch cores, rails, rollers, etc.

<b>Mechanical properties of all-weld metal</b> (typical values)	<b>Hardness as welded HB</b>	<b>Hardness Strain-hardened HRC</b>
	approx. 250	approx. 54

<b>Weld metal analysis</b> ( typical, wt. % )	<b>C</b>	<b>Mn</b>	<b>Ni</b>
	0,8	14	3

**Current** = + / ~ 65 V

**Welding positions** PA, PB, PC, PD, PE

**Rebaking** 1 h, 350 °C + / - 10 °C ( if required )

**Flux-cored wire equivalent** CARBO F- 240

Dia./Length	Amperage (A)	Pcs./ packet	Pcs./ carton	kg / 1000	kg / packet	kg / carton
3,2 x 450	90 – 120	119	476	50,6	5,0	20,0
4,0 x 450	110 – 160	78	312	76,6	5,0	20,0
5,0 x 450	150 – 200	54	216	119,7	5,0	20,0
6,0 x 450	180 - 240	38	152	172,4	6,0	24,0

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