

Classification : E9-UM-250-KPZ (DIN8555)

E 299 R 53 (ISO 3581-A / EN 1600)

E 312-26 (AWSA5.4)

### Properties :

Electrode synthétique à haut rendement (160%) et à enrobage rutile. Haute résistance à la fissuration. Fusion très douce, très peu de projections, auto-détachable slag.

### Applications :

Recharging and assembling high-strength steels between them and with stainless steels, tool and spring steels, Mn ausenistic steels (mold repair). Use up to 1000 degrees Celsius. Also recommended as a sub-layer before reloading hard, and for welding galvanized sheets.

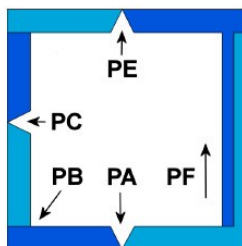
### Mechanical characteristics :

Re > 550 MPa	Rm = 700 MPa	A <sub>5</sub> D > 25 %	Dureté : +/- 240 HB
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### Packaging / Welding recommendations :

Ø mm	2,5	3,2	4
Poids étui (kg)	5	5	6
Intensité (A)	70-100	100 - 140	150 - 200

- Continuous current (+ at electrode) or alternative (U<sub>o</sub> > 70V).
- T° maximal between the passes: 150°C.
- Heating process - 2h à 250 °C if necessary.
- Avoid extended stays at 600 - 850°C (Sigma phase training).



### Welding positions:

**Responsibility:** The purpose of this document is to assist the user in choosing the product. It is up to the user to verify that the chosen product is suitable for the applications for which it is intended. We reserve the right to modify the characteristics of its products without notice. Descriptions, illustrations and features are provided as an indication and cannot be the responsibility of our company. Smoke: View information on the Security Data Sheet available on request