

Classification : E10-GF-UM-65-GTZ (DIN 8555)

E Fe15 (DIN/EN 14700)

### Properties :

Very high-efficiency tubular electrode (300%), very rich in chromium and carbon, and allied to the Mn. The deposit is very resistant to wear by abrasion combined with major shocks.

The design of this electrode allows it to be used at small diameter amperages and to make significant metal deposits in a short time. The reloading deposited is extremely hard from the first pass.

### Applications :

Recharging of austenitic or allied steels subjected to very severe wear by abrasion and shocks combined. Bucket, agricultural and T.P. protections, brickwork press, shredder hammers, mixer arms, mixer blades, sieve grates, plowing tools, Archimedes screws, pump components, coke oven carts,

### Hardness :

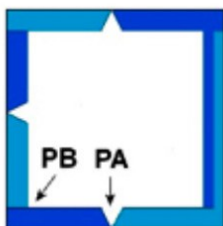
63 HRc (60 HRc at the very first pass)

### Packaging / Welding recommendations :

Ø x lg (mm)	6 x 457	8 x 457	11 x 457
Intensité	80 - 110	120 - 140	140 - 180
Kg / Etui	5	5	5
Pièces / Etui	67	38	22

- Continuous current (+ Electrode) or alternative (U<sub>o</sub> > 50V).
- Hold the electrode perpendicular to the piece and maintain a short arc (2 à 5 mm).
- Heating process : 1h to 150 °C if necessary

Welding position :



Equivalent to stuffed wire : ISAFIL 56

**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