

Classification : E10-UM-250-KNP (DIN 8555)

EFeMn-B (AWS A5.13)

### Properties :

High-efficiency electrode (approximately 140%) depositing a particularly hard and tenacious alloy for reloading parts under heavy shock and compression stresses. The deposit is amagnetic and collapses as a result of violent shocks. Electrode can also be used as a sublayer on steels that are strongly allied or allied to manganese.

Easy priming and very gentle fusion.

### Applications :

Reloading parts subjected to violent shocks with or without abrasion. Underlay before hard reloading. Protection of crusher and shredder parts. Repairs of railway track components, drilling trepans, rotary furnace rings. Reconstruction of worn parts by shocks or abrasion, on high thicknesses

### Hardness

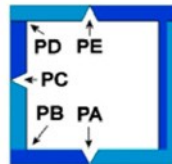
250 HB nuttyable up to 55 HRc

### Packaging / Welding recommendations :

Ø x lg (mm)	2,5 x 350	3,2 x 450	4,0 x 450
Intensité	60 - 100	90 - 120	110 - 160
Kg / Etui	5	6	6
Pièces / Etui	155	86	57

- Continuous current (+ per electrode) or alternative (Uo > 65V).
- Weld the aushenistic steels with manganese at the lowest possible temperature, perhaps even by cooling the room during welding.
- Choose preheating temperatures and between passes as directed by the steel manufacturer.
- The wear resistance of the deposited metal can be greatly increased by grinding (cold hammering).
- Heating process: 1h at 350 °C if necessary

### Welding position :



### Wear Resistances :



Equivalent to stuffed wire ISAFIL250 K

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