

Classification : E 10-UM-60-GTR (DIN 8555)

EFe14 (DIN EN 14700)

EFeCr-A1 (AWS A5.13 / 21)

Characteristics :

ISARC 56 is a thick-coated, high-efficiency electrode with a 170% transfer hard load. Suitable for applications subject to heavy mineral abrasion wear, combined with moderate impact, medium shocks and compression, as well as moisture and moistness. Welding metal is almost dairy-free.

It is advisable to apply a buffer layer before surfacing on old veneers.

Applications :

Mainly used on pump bodies, blender blades, agitator arms, concrete pumps, endless conveyor screws and coke oven slides

Hardness of added metal : **HRC** ca. 63 (type of value)

Wear resistance :



Analyse of the welded metal :

	C	Si	Cr	Autres
(% of weight)	5	1	34	env. 2

Electrical current : = + / ~ / 50 V

Welding passes : PA, PB

Post-drying : 1 h, 130°C +/- 10°C (if necessary)

Equivalent to stuffed wire : ISAFIL 56

Diam/Long	Ampere (A)	Unités/package	Unités/box	kg/1000	kg/package	kg/box
2,5 x 350	70 - 110	152	608	32,9	5,0	20,0
3,2 x 300	100 - 130	90	359	55,7	5,0	20,0
4,0 x 450	140 - 180	55	221	108,4	6,0	24,0
5,0 x 450	180 - 230	35	142	169,4	6,0	24,0
6,0 x 450	200 - 270	25	98	243,9	6,0	24,0

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