



Classification : E2-UM-60 (DIN 8555)

Properties :

Rutilo-basic coating electrode for recharging parts subjected to strong abrasion as well as significant pressure or shocks. Metal deposited soaking in the air, very good compromise between resistance to abrasion and shocks.

Compact deposit free of porosity or cracks, possible milling, excellent weldability even with low priming voltage stations. Soft fusion, few projections, very spread cord.

Applications :

Recharging and rebuilding tools, machine mounts, scrapers, buckets and attack tools, chisels, transporting screws, etc.

Hardness

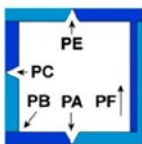
+/- 600 HB (55 - 60 HRc)

Packaging / Welding recommendations :

Ø x lg (mm)	Intensité	Kg / Etui	Pièces / Etui
2,5 x 350	90	5	240
3,2 x 350	80 - 120	5	142
4,0 x 450	110 - 160	6	88
5,0 x 450	150 - 200	6	56

- Continuous current (+ at electrode) or alternative ($U_o > 45V$).
- Use ISARC 307 in underlay on highly allied steels, taking care to preheat and ensure slow cooling down of the item
- Choose preheating temperatures and between passes as recommended by the steel manufacturer (200 - 400oC)..

Welding positions :



Wear resistance :



Equivalent to stuffed wire : ISAFIL 569

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