



Classification : E10-UM-70-GRZ (DIN 8555)

Properties :

High yield hard reload electrode (210%), depositing a heavily loaded alloy of complex carbides, highly resistant to wear by abrasion under moderate shocks, at serving temperatures up to 600°C.

Easy enough use in position, which is rare for electrodes of this type, soft and very nice fusion, dairy almost non-existent.

Applications :

Reloading parts used in agglomeration facilities by sintering, steel mills (blast furnace bells), hot screens, ore processing facilities (including burning coke and slag), cement plants (rotating furnaces, grinders).

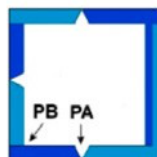
Hardness

69HRc at 20 °C(64 HRc at 600 °C)

Packaging / Welding recommendations :

Ø x lg (mm)	3,2 x 350	4,0 x 450	5,0 x 450
Intensité	110 - 140	140 - 180	180 - 230
Kg / Etui	5	6	6
Pièces / Etui	88	55	35

- Continuous current (+ at electrode) or alternative (Uo > 50V).
- Choose the preheating and between the passes accordingly to the steel fabricator indications.
- In case of application on old hard recharging, we recommend applying an underlayer with electrode ISARC307.
- Limit the deposit to 2 passes.
- Heating Process : 1h at 130°C if necessary.



Welding position :

Wear resistance :

