

Standards	DIN 8555	E 10-UM-65-GTRZ										
Approvals	---											
Characteristics	CARBODUR 61 is a heavy coated high efficiency hardfacing electrode with 240 % recovery. The weld metal has a ledeburitic structure with an alloy containing carbides of different kinds. CARBODUR 61 is used for hardfacing of parts subject to strong abrasive wear, friction, heat and corrosion. The weld metal is nearly free of slag. A buffer layer of CARBO 4370 MPR is recommended prior to surfacing on old claddings.											
Typical applications	Hardfacing on tools used in coal and ore mining as well as in the cement industry.											
Operating temperature												
Hardness of all-weld metal (typical values)	<table><tr><td>HRc</td></tr><tr><td>ca. 64</td></tr></table>		HRc	ca. 64								
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Weld metal analysis (typical, wt. %)	<table><tr><td>C</td><td>Si</td><td>Cr</td><td>Nb</td><td>Others</td></tr><tr><td>5,2</td><td>2,2</td><td>29</td><td>6,8</td><td>approx. 3,5</td></tr></table>		C	Si	Cr	Nb	Others	5,2	2,2	29	6,8	approx. 3,5
C	Si	Cr	Nb	Others								
5,2	2,2	29	6,8	approx. 3,5								
Current	= + / ~ 50 V											
Welding positions	PA, PB											
Rebaking	1 h, 150°C + / - 10 °C (if required)											
Flux-cored wire equivalent	CARBO F- 61											

Dia./Length	Amperage (A)	Pcs./ packet	Pcs./ carton	kg / 1000	kg / packet	kg / carton
2,5 x 350	80 – 110	126	504	39,7	5.0	20.0
3,2 x 350	100 – 140	75	298	67,1	5.0	20.0
4,0 x 450	130 – 180	46	184	130,7	6.0	24.0
5,0 x 450	170 – 240	29	117	204,3	6.0	24.0

Rev. 000

Statements on composition and application are just for the applier's information. Statements on mechanical properties always refer to the all-weld-metal according to valid standards. Carbo-Weld may change the characteristics of its products without notice. We recommend the applier to check our products for their special application autonomously.