

Revisionsnummer: 2

Classifications

DIN 8555	EN 14700
E 6-UM-60	E Fe8

Characteristics and typical fields of application

WEARstick Dur 650 is suitable for cladding structural parts subject to abrasion combined with impact. The main applications are tools in the earth moving industry and crushing plants as well as cold and hot working tools. The deposit is only machinable by grinding.

WEARstick Dur 650 is a martensitic alloy. The stick electrode is suited in impact and pressure stress situations. Machining of the weld metal only by grinding.

Hardness of the pure weld deposit: 58 – 60 HRC

1 layer on high Mn-steel: approx. 24 HRC

2 layers on high Mn-steel: approx. 45 HRC

Typical analysis

	C	Si	Mn	Cr	Mo	Nb	Fe
wt.-%	0.5	0.8	1.3	7.0	1.3	0.5	bal.

Operating data

	Polarity	DC + / AC	Dimension mm	Current A
	Redrying	2 h / 300° C	3.2 × 450	80 – 110
			4.0 × 450	130 – 170
			5.0 × 450	160 – 200
			6.0 × 450*	190 – 230

* available on request

Welding instructions

Hold stick electrode as vertically as possible, keep a short arc. Preheating of non-alloyed steels is not necessary. Preheat heavy parts and high-tensile base materials to 250 – 350 °C. If more than 3 – 4 layers are needed, apply the softer stick electrodes WEARstick Dur 250 or WEARstick Dur 300 for buildup. On high Mn-steel, WEARstick MnCr13 should be used. Redry stick electrodes that have got damp for 2 h / 300 °C.

Approvals

-