



# CEWELD E DUR SS 60Ti

**TYPE** Hardfacing electrode for cutting edges and many overlay applications.

**APPLICATIONS** Developed for wear resistant overlays that faces high working temperatures and excellent for rebuilding cutting edges of knives and other cutting equipment.

**PROPRIÉTÉS** Outstanding alloy against abrasion, impact and high temperatures up-to 550 °C. The weld deposit of CEWELD DUR SS 60Ti is more or less comparable with HSS (High Speed Steel) and will offer outstanding welding properties on both AC and DC+ Recommended for manufacturing and reconditioning cutting tools.

**CLASSIFICATION**

AWS	A 5.13: ~E Fe6
EN ISO	14700: E Fe4
DIN	8555: E4-UM-60-ST
F-nr	71

**CONVIENT POUR** Cutting tools, Shear blades, Milling cutters, Drills, Hot work tools, wood knives etc. High speed Tool steel deposit.

**AGRÉMENTS**

**POSITIONS DE SOUDAGE**



**TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)**

C	Si	Mn	Mo	V	Fe	W	Cr
0.9	0.4	1	8	1.5	Rem.	2	5

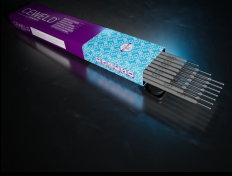
**PROPRIÉTÉS MÉCANIQUES**

Heat Treatment	R <sub>p0,2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Hardness
As Welded				60 HRc

**ETUVAGE** 300°C / 2 hr

**HARDNESS** 58 - 62 [HRC] Welded condition 63 - 65 [HRC] Tempered (530°C) 250 [HB] Soft annealed (810°C) 60 - 63 [HRC] Hardened at 1220°C

**GAS ACC. EN ISO 14175**



# CEWELD E DUR SS 60Ti

E DUR SS 60Ti 2,5 X 350MM	Packaging	KG/unit	EanCode
	Can	2,4	8720663401724
E DUR SS 60Ti 3,2 X 350MM	Packaging	KG/unit	EanCode
	Can	2,5	8720663401731
E DUR SS 60Ti 4,0 X 350MM	Packaging	KG/unit	EanCode
	Can	2,5	8720663401748