



CEWELD E DUR 64

TYPE Basic coated, high Chromium-Niobium based Hardfacing high recovery hardfacing electrode

APPLICATIONS This electrode with a recovery of 190% can be used for overlays with extremely abrasive and sliding

wear resistance, but with middle impact.

PROPRIÉTÉS Due to the high Mo-content, abrasion resistance can be kept up to working temperatures of 600 °C;

the hardness is still 40-45 HRc at these temperatures. For Hardfacing of more than 3 layers it is necessary to buffer with an electrode like CEWELD® E DUR 350 Kb that delivers a welding deposit of less hardness. Overlays on steel with high tensile strength have to be buffered with CroNi 29/9 HL or

4370 HL. Equivalent in FCAW: CEWELD® OA 64

CLASSIFICATION AWS A 5.13: E FeCr-E4

EN ISO 14700: E Fe16

DIN 8555: E 10-UM-65- GTZ

F-nr 71

CONVIENT POUR Sugar mill knives and Hammers, Clinker crushers, Sintering lines, Fire gratings, Mixer blades,

Gravel washing equipment, Ceramic mixer blades, Mill rollers, Stone crushers, Cxtruders etc....

AGRÉMENTS

POSITIONS DE SOUDAGE



TYPICAL CHEMICAL

ANALYSIS OF WELD METAL

(%)

С	Mn	Cr	Мо	Nb	V	Fe	W	Si
5.5	0.6	24	6	6	1	Rem.	2	0.9

PROPRIÉTÉS MÉCANIQUES

Heat	R _{P0,2}	Rm	A5	Hardness	
Treatment	(MPa)	(MPa)	(%)		
As Welded				61 HRc	

ETUVAGE 300°C / 2 hr

GAS ACC. EN ISO 14175





CEWELD E DUR 64

E DUR 64 3,2 X 350MM	Packaging	KG/unit	EanCode		
	Can	2,4	8720663402677		
E DUR 64 4,0 X 450MM	Packaging	KG/unit	EanCode		
	Can	3,0	8720663402684		
E DUR 64 5,0 X 450MM	Packaging	KG/unit	EanCode		
·	Can	2,9	8720663402691		