

## Repair electrode

### Classification

AWS A5.11M-97 : ENiCrMo-5\*  
 DIN 8555-83 : E23-UM-200-CKPTZ

\* Nearest classification

### General description

Rutile coated stick electrode - weld deposit rate 170% - for hardfacings on machine components and tools subjected to corrosion and heat.

Weld metal comprises low iron nickel-chromium-molybdenum-tungsten-alloy.

Smooth stable arc.

Low dilution with the parent material.

Slag easily removable.

### Welding positions



ISO/ASME PA/1G PB/2F

### Current type

AC / DC electrode +

### Chemical composition (w%), typical, all weld metal

C	Si	Mn	Cr	Mo	W	Fe	Ni
0.02	0.9	0.9	16	17	4.0	6.5	balance

### Mechanical properties, all weld metal

	Typical hardness values
As deposited	225 HB
Work hardened	400 HB

### Packaging, available sizes and identification

	Diameter (mm)	3.2
	Length (mm)	350
Unit: PE tube	Pieces / unit (nominal)	40
	Net weight unit (kg)	2.5

Identification Imprint: RepTec 34

Tip colour: violet

RepTec 34: rev. EN 15

## Materials to be welded

Hardfacings on new or damaged hot working tools, such as: forging dies, forging saddles, hot-shearing blades, hot-trimming dies, hollow-

## Calculation data

Sizes Diam. x length (mm)	Current range (A)	Current type	Arc time - per electrode at max. current - (s)*	Energy E(kJ)	Dep.rate H(kg/h)	Weight/ 1000 pcs. (kg)	Electrodes/ kg weldmetal B	kg Electrodes/ kg weldmetal 1/N
3.2 x 350	110-140	-	-	-	-	59	-	-

\* stub end 35mm

## Welding parameters, optimum fill passes

Welding positions Diameter (mm)	Current (A)
3.2	120

## Remarks

In the case of great hardfacing thicknesses, fill beforehand, e.g. with RepTec 29. Heat up to 300°C with components made from parent materials suscepti-

## Application advice

Untreated weld metal machinable