

Wearshield® 50MC

Hardfacing electrode

Classification

DIN 8555-83 : E10-UM-65-GRZ

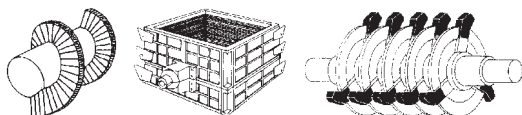
General Description

Basic coated electrode for hardfacing with an efficiency of about 200%.
Extreme resistance against abrasion up to temperatures of 700°C.

Application

Typical applications include:

Ore-crushers, ore chutes, hot slag crushers, dragline teeth, diggers, etc.



Mechanical properties, all weld metal

Typical hardness values

1 Layer 62-67 HRc

Welded on Mild Steel Plate

Packaging, available sizes and identification

	Diameter (mm)	3.2	4.0
	Length (mm)	350	350
Unit: Box	Pieces / unit (nominal)	41	27
	Net weight (kg)	2.5	2.5

Identification Imprint: Wearshield 50 MC

Tip colour: white

Wearshield® 50MC: rev. EN 15

Wearshield® 50MC

Additional information

By preference, weld under inclined angle of 20 degrees.

Weave during welding in a width of approx. 50 mm.

During solidification small cracks will occur.

These cracks, however, will have no detrimental effect on the weld metal properties regarding its abrasive wear resistance.

A maximum of two layers should be applied to prevent the weld from braking out.

Welding positions



ISO/ASME PA/1G PF/3G up

Current type

AC / DC electr. +

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

C	Mn	Cr	Nb	W	V	Si	B
5	2	21	6.4	3.1	0.7	2.1	0.8

Structure

Supereutectic + primary carbides.

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	120 - 160	DC+	156	699	1.28	67	18	1.21
4.0 x 350	160 - 200	DC+	172	1011	1.50	100	14	1.40

* stub end = 35 mm

Complementary products

Complimentary products include flux cored wire Lincore® 65-O.