

Standards	DIN 8555	E 10-UM-60-GTR
	DIN EN 14700	E Fe14
	AWS A5.13 / 21	EFeCr-A1

Approvals ---

Characteristics CARBODUR 63 is a heavy coated high efficiency hardfacing electrode with 170 % recovery. Suitable for applications subject to strong abrasive wear by minerals, combined with moderate impact, medium shocks and compression as well as humidity or wetness. The weld metal is nearly free of slag. A buffer layer of CARBO 4370 MPR is recommended prior to surfacing on old claddings.

Typical applications mainly used on pump bodies, mixer blades, agitator arms, concrete pumps, conveyer worms and coke-oven slides.

Operating temperature

Hardness of all-weld metal (typical values)	HRc
	ca. 63

Weld metal analysis (typical, wt. %)	C	Si	Cr	Others
	5	1	34	approx. 2

Current = + / ~ 50 V

Welding positions PA, PB

Rebaking 1 h, 130°C + / - 10 °C (if required)

Flux-cored wire equivalent	CARBO F- 59
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Dia./Length	Amperage (A)	Pcs./ packet	Pcs./ carton	kg / 1000	kg / packet	kg / carton
2,5 x 350	70 - 110	152	608	32,9	5.0	20,
3,2 x 350	100 - 130	90	359	55,7	5.0	20,0
4,0 x 450	140 - 180	55	221	108,4	6.0	24,0
5,0 x 450	180 - 230	35	142	169,4	6.0	24,0
6,0 x 450	200 - 270	25	98	243,9	6.0	24,0

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