

**Standards**

**Approvals**

**Characteristics**

Thickly coated high efficiency electrode with approx. 240 % recovery.  
The weld metal structure is ledeburitic, the alloy contains carbide forming elements of different kinds.  
CARBODUR 69 is mainly used for applications where parts are subject to strong abrasive wear since the deposited alloy is highly resistant to abrasion.  
Smooth fusion, almost slag-free deposit.  
Prior to surfacing on old hardfacing layers a buffer layer with CARBO 4370 MPR is recommended.

**Typical applications**

CARBODUR 69 is mainly used for hardfacing on equipment in sintering plants, steel mills, coke oven plants, coal excavation and overburden removal, etc.

**Mechanical properties of all-weld metal**

(typical values)

Hardness HRC
58 - 62

**Weld metal analysis**  
(typical, wt. %)

C	Mo	Cr	B	V
4,0	2	25	1,75	0,5

**Current**

= + / ~ 50 V

**Welding positions**

PA, PB

**Rebaking**

1 h, 150 °C + / - 10 °C ( if required )

Dia./Length	Amperage (A)	Pcs./ packet	Pcs./ carton	kg / 1000	kg / packet	kg / carton
2.5 x 350	80 – 110	148	592	33,8	5.0	20,0
3.2 x 450	110 – 140	88	350	57,1	6.0	20,0
4.0 x 450	140 – 180	54	216	111,1	6.0	24,0
5.0 x 450	180 – 230	35	138	173,6	6.0	24,0

Rev. 000

Statements on composition and application are just for the applier's information. Statements on mechanical properties always refer to the all-weld-metal according to valid standards. Carbo-Weld may change the characteristics of its products without notice. We recommend the applier to check our products for their special application autonomously.

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