

<b>Standards</b>	DIN 8555	E 10-UM-65-GTRZ
	DIN EN 14700	E Fe16

**Approvals** ---

**Characteristics** CARBODUR 61 is a heavy coated high efficiency hardfacing electrode with 240 % recovery.  
The weld metal has a ledeburitic structure with an alloy containing carbides of different kinds.  
CARBODUR 61 is used for hardfacing of parts subject to strong abrasive wear, friction, heat and corrosion.  
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** Hardfacing on tools used in coal and ore mining as well as in the cement industry.

### Operating temperature

<b>Hardness of all-weld metal</b> ( typical values)	<b>HRc</b>
	ca. 64

<b>Weld metal analysis</b> (typical, wt. %)	<b>C</b>	<b>Si</b>	<b>Cr</b>	<b>Nb</b>	<b>Others</b>
	5,2	2,2	29	6,8	approx. 3,5

**Current** = + / ~ 50 V

**Welding positions** PA, PB

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

<b>Flux-cored wire equivalent</b>	CARBO F- 61
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Dia./Length	Amperage (A)	Pcs./ packet	Pcs./ carton	kg / 1000	kg / packet	kg / carton
2,5 x 350	80 – 110	126	504	39,7	5.0	20.0
3,2 x 350	100 – 140	75	298	67,1	5.0	20.0
4,0 x 450	130 – 180	46	184	130,7	6.0	24.0
5,0 x 450	170 – 240	29	117	204,3	6.0	24.0

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