

## EH 360B

Sert Dolgu Uygulamaları için Örtülü Elektrod -

### Standards

EN 14700	E Fe8
TS EN 14700	E Fe8
DIN 8555	E 6-UM-60-GPT

### Özellikleri ve Uygulama Alanları

Thick basic-covered electrode for depositing tough and wear resisting overlays on structural members, subjected to severe wear. It is particularly resistant to high metal-to-metal wear, moderate impact and abrasion. The weld metal has sufficient red hardness up to 600°C. It can be machined only by grinding. Multi-layers deposits will be free of cracks, even without depositing intermediate buffer layers. Only in case of very crack sensitive base metals, a tough buffer layer, made with ESB 42 or EI 307B electrodes, is required. Preferred to use with DC, electrode in positive (+) pole and also possible to use with AC.

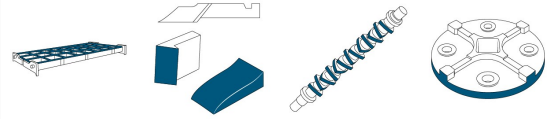
**Typical Applications:** Suitable hardfacing applications where wear resistance at higher temperatures is a prime concern, as in hot cut offs, dies for pressure castings, rolls, crushers excavator parts, bucket edges and bucket teeth, drilling bits, coal planes, conveyor screws.



### Dayanım Gösterdiği Aşınma Tipleri

Abrasion	■	■	■	■
Adhesion	■	■	■	■
Impact	■	■	■	■
Sıcaklık	■	■	■	■
Corrosion	■	■	■	■
	Düşük	Medium	Yüksek	Çok Yüksek

### Typical Applications



### Kaynak Metalinin Tipik Kimyasal Özellikleri

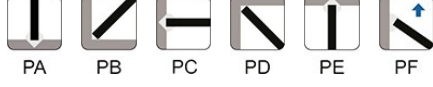
Type of Analysis	C	Si	Mn	Cr	Mo	V	Fe
Weld Deposit	0,50	0.80	0.60	8.00	0,50	0.65	88.95

### Kaynak Metalinin Tipik Mekanik Özellikleri

Test Şekli	Hardness (HRC)	Aşınma İndeksi
Kaynak Sonrası	59	62.34 (SiO <sub>2</sub> )

## Application Information

## Kullanılabilecek Kaynak Pozisyonları



## Polarity:



## Welding Parameters &amp; Efficiency

Çap x Uzunluk (mm)	Akım (A)	Weld Deposit(Kg)/1Kg Consumed Electrode	Number of Electrodes/1Kg Weld Deposit	Kaynak Metali Yığıma Hızı (kg/saat)	Efficiency(%)
2.50x350	80-90	0,65	73	0,75	120
4.00x350	140-180	0,65	28	1,37	121
5.00x450	180-210	0,68	14	2,16	121
3.25x350	100-140	0,65	43	1,01	122
4.00x450	140-180	0,68	21	1,47	122

## Packaging Information

Ürün Kodu	Çap X Uzunluk (mm)	Pieces per Box (~)	Kutu Ağırlığı (kg)	Number Of Boxes Per Package	Koli Ağırlığı	Packaging Type
18006HDEM2	2.50x350	120 kg	2.5	3	8.1	Plastic Box
18006HEEM2	2.50x350	241 kg	5.0	3	15.8	Plastic Box
18006HREM2	2.50x350	241 kg	5.0	3	15.4	Cardboard Box
18006NDEM2	3.25x350	71 kg	2.5	3	8.1	Plastic Box
18006NEEM2	3.25x350	141 kg	5.0	3	15.8	Plastic Box
18006NREM2	3.25x350	141 kg	5.0	3	15.4	Cardboard Box
18006QEEM2	4.00x350	93 kg	5.0	3	15.8	Plastic Box
18006QREM2	4.00x350	93 kg	5.0	3	15.4	Cardboard Box
18006SFEM2	4.00x450	92 kg	6.5	3	20.4	Plastic Box
18006SSEM2	4.00x450	92 kg	6.5	3	19.9	Cardboard Box
18006VSEM2	5.00x450	61 kg	6.5	3	19.9	Cardboard Box

## Storage &amp; Re-Drying Information

It can be dried maximum 5 times.  
It has to be dried at 350°C for 2 hours.