

EH 360B

Covered Electrode for Hardfacing Applications -

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

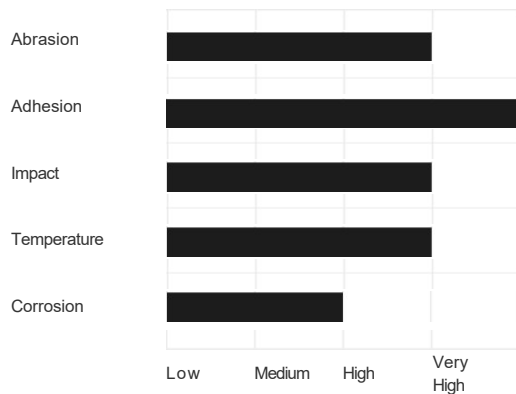
Properties and Applications

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.

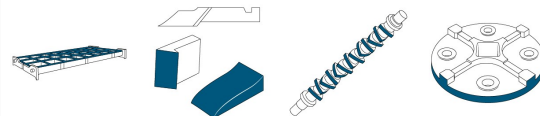
Typical Applications: Suitable hardfacing applications where wear resistance at higher temperatures is a prime concern, as in hot cut offs, dies for pressure castings, rolls, crushers excavator parts, bucket edges and bucket teeth, drilling bits, coal planes, conveyor screws.



Wear Resistance Types



Typical Applications









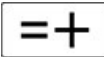

Typical Chemical Values of Weld Metal

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

Typical Mechanical Values of Weld Metal

Test Condition	Hardness (HRC)	Wear Index
As welded	59	62.34 (SiO2)

Application Information

Welding Positions						Polarity:	
							
PA	PB	PC	PD	PE	PF		
Welding Parameters & Efficiency							
Diameter x Length (mm)	Current (A)	Weld Deposit(Kg)/1Kg Consumed Electrode	Number of Electrodes/1Kg Weld Deposit	Weld Metal Deposition Rate (Kg/h)	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

Product Code	Diameter X Length (mm)	Pieces per Box (-)	Weight Of The Box (kg)	Boxes Per Package	Weight Of The Package	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 & Re-Drying Information

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