

GeKa®

ELHARD 600 R

Standards :

| | | |
|-------------|---|------------|
| TS EN 14700 | : | E Fe 8 |
| EN 14700 | : | E Fe 8 |
| DIN 8555 | : | E6-UM-60 P |

**Chemical Composition of Weld Metal-
% (Typical) :**

| | | | | | |
|-----|-----|-----|-----|-----|-----|
| C | Mn | Si | Mo | V | Cr |
| 0.5 | 0.3 | 1.1 | 1.0 | 1.0 | 7.0 |

Mechanical Properties : _____

| |
|------------------------------|
| Weld Metal Hardness (HRC) |
| 55 - 59 |

Typical Base Material Grades : _____

- * Electrode covering of rutile character.
- * Usability with a welding transformer (Weldability with AC).
- * Weld metal with ductile and cracking-resistant behaviors.
- * Requirement of re-drying at the temperature range of 300-350°C for 2 hours.
- * Applicability in final layer welding of earth and mineral mining machines, impact drilling and crushing devices, guide springs, edges of cutting tools, hard manganese steels, bucket edges and teeth

Welding Positions : _____



Current Type : _____

- D.C.(+)
- A.C.

Operating Data : _____

| Diameter x Length (mm) | Diameter x Length (inch) | Welding Current (A) | Weight g /100 pcs |
|---------------------------|-----------------------------|------------------------|----------------------|
| 3.20 x 350 | 1/8 x 14" | 90 - 135 | 4095 |
| 4.00 x 450 | 5/32 x 18" | 135 - 180 | 8170 |
| 5.00 x 450 | 3/16 x 18" | 180 - 230 | 12020 |

Approvals : _____