

**GeKa®**

**ELHARD 63**

**Standards :**

TS EN 14700	:	E Fe 14
EN 14700	:	E Fe 14
DIN 8555	:	E 10-UM-60 GRZ
AWS A5.13	:	~E FeCr-A8

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

C	Cr	Si	Mn
4.5	34.0	1.0	0.5

**Mechanical Properties :** \_\_\_\_\_

Hardness (HRC)
60 - 64

**Typical Base Material Grades :** \_\_\_\_\_

\* Special coating, high-chromium carbide electrode for hardfacing operations to provide maximum resistance to extreme mineral abrasion.

\* A typical application is stringer beads on earth-moving, cement mill and brick making equipment.

\* Preheating generally not required, metal recovery is approx. 220%.

\* Re-drying : 300-350°C / min. 2 h

**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"	125 - 160	5200
4.00 x 350	5/32 x 14"	140 - 200	7200
5.00 x 350	3/16 x 14"	190 - 260	12190

**Approvals :** \_\_\_\_\_