

Hardfacing Electrode

GeKa®

ELHARD 14 Mn

Standards :

TS EN 14700	:	EZ Fe 9
EN 14700	:	EZ Fe 9
DIN 8555	:	E 7-UM-200K
AWS A5.13	:	E FeMn-A

Chemical Composition of Weld Metal- % (Typical) :

C	Mn	Si	Ni
0.60	13.5	0.1	3.0

Mechanical Properties :

Hardness (HB)	Hardness After Cold Deformation (HB)
180 - 220	~550

Typical Base Material Grades :

- * Hardfacing of mining and rock-crushing machine parts as well as of hard manganese steels.
- * Machinability of weld metal only if it is not hammered when it is cold, or, if it is not put into operation for a while.
- * Re-drying at condition 300 °C / 2 h is required.

Welding Positions :



Current Type :

D.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"	110 - 140	3580
4.00 x 450	5/32 x 18"	150 - 180	7100
5.00 x 450	3/16 x 18"	180 - 210	11170

Approvals :