

EZ - 650 TN

CLASSIFICATION

EN 14700	DIN 8555
E Fe 2	E6-UM-60

DESCRIPTION AND APPLICATION

A basic heavily coated electrode for hard buildups. The deposit is hard, tough and abrasion resistant to hardness up to 500 HV. Weld is machinable only by grinding. When hardfacing apply medium welding current and no weaving of electrode is recommended.

At multilayer hardfacing it is recommended to weld buffer layer with electrode EZ - KROM 20.

MECHANICAL PROPERTIES OF THE ALL-WELD METAL

Hardness HRC
57 - 62

APPROXIMATE CHEMICAL COMPOSITION OF THE ALL-WELD METAL

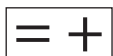
	C	Mn	Si	Cr	Mo
%	0,5	2,0	1,4	6,0	0,6

RECOMMENDED WELDING CURRENT

Ø mm	2,5	3,2	4,0	5,0	6,0
A	70 - 90	110 - 130	150 - 170	200 - 240	250 - 290

PACKAGING

Electrode dimensions mm	Quantity per ton approx. pieces	Weight of packaging kg
Ø 2,5 x 300	53 100	3,2
Ø 3,2 x 350	27 600	3,8
Ø 4,0 x 450	15 600	4,8
Ø 5,0 x 450	10 200	5,4
Ø 6,0 x 450	7 100	5,5



Marking: **EZ - 650 TN**