

Classifications

DIN EN 14700	DIN 8555
E Fe14	E 10-UM-60-GRZ

Characteristics and typical fields of application

WEARstick XD 60 is universally applicable on parts predominantly subject to grinding abrasion combined with light impact, such as conveyor screws, digging teeth, sand pumps and mixer wings.

It is also suited as a final layer on tough-hard deposits (WEARstick Dur 600) or high Mn-steel (WEARstick MnCr13).

WEARstick XD 60 has excellent welding characteristics and a very easy slag removal. The homogeneous and finely-rippled seam surface does, for most applications, not require any finishing by grinding.

Hardness of the pure weld metal: approx. 60 HRC


1st layer on steel with C = 0.15%: approx. 55 HRC

1st layer on high Mn-steel: approx. 52 HRC

Typical analysis

	C	Si	Cr	Fe
wt.-%	3.0	1.3	29.0	bal.

Operating data

	Polarity	DC + / AC	Dimension mm	Current A
	Redrying	300°C / 2 h	2.5 × 300	50 - 80
			3.2 × 350	90 - 120
			4.0 × 350	120 - 150

Keep an angle of 80-90° between plate and electrode, and keep a short arc. Preheating is in general not necessary. On multipass-welds, a cushion layer with UTP 630 is recommended to prevent hardening cracks in the weld deposit.

Approvals

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