

International standards	DIN 8555	E 7-UM-250-KP
	AWS A56.13	E FeMn-A

Approvals ---

Characteristics Basic coated, AC-weldable electrode with approximately 120 % recovery. Due to the weld metal's high tenacity and hardness, CARBODUR Mn is suitable for hardfacing on parts which are subject to extreme impact stress and cavitation. A considerable increase in wear resistance through strain hardening can be achieved by cold-hammering.

Operating temperature ---

Typical applications Excavator teeth, crushing hammers, rings in rotary furnaces, rail switch cores, rails, rollers, etc.

Mechanical properties of all-weld metal (typical values)	Hardness as welded HB	Hardness Strain-hardened HRC
	approx. 250	approx. 54

Weld metal analysis (typical, wt. %)	C	Mn	Ni
	0,8	14	3

Current = + / ~ 65 V

Welding positions PA, PB, PC, PD, PE

Rebaking 1 h, 350 °C + / - 10 °C (if required)

Flux-cored wire equivalent CARBO F- 240

Dia./Length	Amperage (A)	Pcs./ packet	Pcs./ carton	kg / 1000	kg / packet	kg / carton
3,2 x 450	90 – 120	119	476	50,6	5,0	20,0
4,0 x 450	110 – 160	78	312	76,6	5,0	20,0
5,0 x 450	150 – 200	50	200	119,7	5,0	20,0