

Standards	DIN 8555	E 10-UM-60-GR
	AWS A5.13 / 21	EFeCr-A1

Approvals ---

Characteristics CARBODUR 55 is a heavy coated high efficiency hardfacing electrode with 160 % recovery. Suitable for applications subject to strong abrasive wear by minerals, combined with moderate impact, medium shocks and compression as well as humidity or wetness. Soft fusion, fin-structured seam surface, self-releasing slag and a shiny surface of deposits

Typical applications mainly used on pump bodies, mixer blades, agitator arms, concrete pumps, conveyer worms, crushing and pulverizing plants, bucket teeth and coke-oven slides.

Operating temperature

Hardness of all-weld metal (typical values)	HRc
	ca. 57

Weld metal analysis (typical, wt. %)	C	Si	Cr	Others
	4,5	01	28	approx. 2

Current = + / ~ 50 V

Welding positions PA, PB

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

Flux-cored wire equivalent	CARBO F- 55
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Dia./Length	Amperage (A)	Pcs./ packet	Pcs./ carton	kg / 1000	kg / packet	kg / carton
2.5 x 350	70 - 110	159	637	31.4	5.0	20.0
3.2 x 350	90 - 130	94	377	53.1	5.0	20.0
4.0 x 450	120 - 160	58	232	103.4	6.0	24.0
5.0 x 450	150 - 230	37	149	161.5	6.0	24.0
6.0 x 450	180 - 260	26	103	232.6	6.0	24.0