

Classifications

DIN 8555	EN 14700
E 1-UM-250	E Fe1

Characteristics and typical fields of application

WEARstick Dur 250 is used for surfacing on parts, where a tough and easily machinable deposit is required, such as rails, gear wheels, shafts and other parts on farming and building machineries. Also suitable as cushion and filler layer on non-alloyed and low-alloyed steels and cast steels.

Hardness of the pure weld deposit: approx. 270 HB
1 layer on steel with C = 0.5 %: approx. 320 HB

WEARstick Dur 250 has a very good resistance against compression and rolling strain. The weld metal is easily machinable.

Typical analysis

	C	Si	Mn	Cr	Fe
wt.-%	0.15	1.1	1.2	0.8	bal.

Operating data

	Polarity	DC + / AC	Dimension mm	Current A
			3.2 × 450	100 – 140
			4.0 × 450	140 – 180
			5.0 × 450	180 – 230
			6.0 × 450 *	230 – 300

* available on request

Welding instructions

Hold stick electrode as vertically as possible and with a short arc. Preheat heavy parts and higher carbon steel qualities to 150 – 300 °C. Redry stick electrodes that have got damp for 2h / 300 °C.

Approvals

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