

# EH 360R

Covered Electrode for Hardfacing Applications -

## Standards

EN 14700	E Fe8
TS EN 14700	E Fe8
DIN 8555	E 6-UM-60-GPT

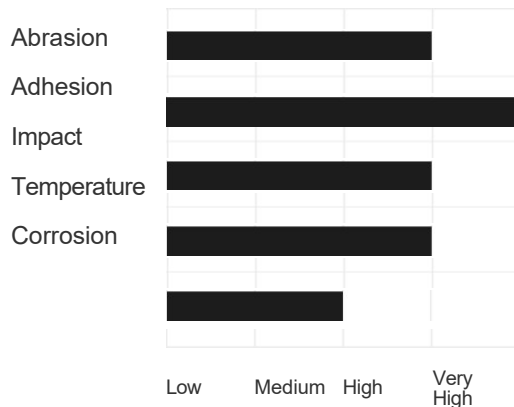
## Properties and Applications

Thick rutile-covered electrode for depositing tough and wear resisting hardfacing overlays. It is particularly resistant to high metal-to-metal wear, moderate impact and abrasion. The weld metal has sufficient red hardness up to +600°C. It is machinable only by grinding. In case of crack sensitive base metals, a tough buffer layer made by ESB 42 or EI 307B electrodes, is required and a further one after every third hardfacing layer. The as-welded hardness of 59 HRC can be increased to 60-65 HRC by single or double tempering. Possible to use equally well both with AC and DC.

**Typical Applications:** Suitable hardfacing applications where wear resistance at higher temperatures is a prime concern, as in hot cut offs, dies for pressure castings, rolls, crushers excavator parts, bucket edges and bucket teeth, drilling bits, coal planes, conveyor screws.



## Wear Resistance Types and Microstructure



## Typical Applications



## Typical Chemical Values of Weld Metal

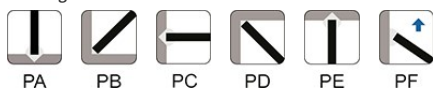
Type of Analysis	C	Si	Mn	Cr	Mo	V	Fe
Weld Deposit	0,50	0,65	0,60	9,00	0,45	0,40	88,85

## Typical Mechanical Values of Weld Metal

Test Condition	Hardness (HRC)	Wear Index
As welded	58	68.92

## Application Information

### Welding Positions



### Polarity:



**Welding Parameters & Efficiency**

Diameter x Length (mm)	Current (A)	Weld Deposit(Kg)/1Kg Consumed Electrode	Number of Electrodes/1Kg Weld Deposit	Weld Metal Deposition Rate (Kg/h)	Efficiency(%)
2.50x350	60-90	0,49	100	0,63	87
3.25x350	100-140	0,5	60	0,83	88
5.00x450	180-210	0,53	18	1,66	91
4.00x450	140-180	0,56	27	1,24	95

**Packaging Information**

PRODUCT CODE	Diameter x Length (mm)	Quantity per box (approx.)	Box Net Weight (kg)	NUMBER OF BOXES IN PACKAGE	Package Net Weight (kg)	Packaging Type
18007HDEM2	2.50x350	133 pcs	2.5	3	8.1	Plastic Box
18007HEEM2	2.50x350	266 pcs	5.0	3	15.8	Plastic Box
18007HREM2	2.50x350	266 pcs	5.0	3	15.4	Cardboard Box
18007NDEM2	3.25x350	73 pcs	2.5	3	8.1	Plastic Box
18007NEEM2	3.25x350	146 pcs	5.0	3	15.8	Plastic Box
18007NREM2	3.25x350	146 pcs	5.0	3	15.4	Cardboard Box
18007SBEM2	4.00x450	15 pcs	1.0	12	13.5	Plastic Box
18007SFEM2	4.00x450	99 pcs	6.5	3	20.4	Plastic Box
18007SSEM2	4.00x450	99 pcs	6.5	3	19.9	Cardboard Box
18007VEEM2	5.00x450	64 pcs	6.5	3	20.4	Plastic Box
18007VSEM2	5.00x450	64 pcs	6.5	3	19.9	Cardboard Box

**Storage & Re-Drying Information**

It can be dried maximum 5 times.  
Generally not required. If required, redry for 2 hour at 150°C.