

## Electrode for Hardfacing (TIG Welding)

# E D S - 6 0 0 T

■ Tip Color                      Purple

■ Application

Super hardfacing on the mold.

Overlaying on cold and hot shearing edge, dipper tooth, roller, cam, impeller breaker, crush hammer, mixer chamber and so on.

Overlaying on the pipe shoot and conveyor which is subject to grinding attrition in high temperature.

■ Features

1. EDS-600T is TIG welding electrode for hardfacing. The deposited metal is martensite structure, which is composed of 0.45%C-2.5%Si-9%Cr.
2. The deposited metal show stable hardness, HRC54~60 as welded. It shows excellent notch toughness and wear resistance at room temperature. Also it has wear resistance at high temperature.

■ Welding Procedures

1. In general, preheating and interpass temperature require more than 200°C
2. For multilayer welding on the hardenable steel such as high-carbon steel, alloy steel and special steel, post heating and slow cooling at 500~600°C are necessary.

■ Typical Chemical Components of the Electrode (%)

C	Si	Mn	Cr
0.40~0.60	2.00~3.00	0.40~0.70	8.00~9.00

■ Typical Hardness of the Deposited Metal as welded

	Hardness
HV	510~700
HRC	50~60
HS	67~81

■ Dimensions

Diameter (mm)	Length (mm)	Minimum Quantity (Kg)
1.2 1.6 2.0 2.5 3.2	1,000	5

Equivalent to electrode for shielded metal arc welding: EA600W  
 Equivalent to wire for MAG welding: EDS-600