

	TECNHICAL DATA SHEET	FT-DQ80
	EUROTROD HD 60	PÁG. 1/1

CLASSIFICATION:

DIN 8555: E 6- UM- 60- GP

CERTIFIED COMPANY:



Management System
 ISO 9001:2015

 www.tuv.com
 ID 1100008183



DESCRIPTION:

Basic type electrode for hard surfacing of parts subject to abrasion with or without impact. Good weld ability in all positions, except vertical downward.

SUITABLE FOR:

Hard facing of parts as bucket teeth, rollers, tracks and other machinery components.

TYPICAL CHARACTERISTICS OF ALL-WELD METAL:

Chemical Analysis (%):

C	Si	Mn	Cr	Mo	V		
0,50	0,45	0,40	7,0	0,50	0,50		

Mechanical Properties:

**Rockwell Hardness HRC:
57-62**

PRODUCT INFORMATION:

WELDING PARAMETERS				PACKING DATA	
Diameter (mm)	Length (mm)	Recommended Current (A)	Current Type (Pole +)	Pieces /Packet (Un)	Weight /Packet (kg)
3,2	450	100 – 120	DC	170	5,5
4,0	450	140 – 160	DC	95	4,9
5,0	450	180 – 220	DC	65	6,7

WELDING POSITIONS:

