

TALARC EA600

MAG-wire electrode

Type: Drawn copper-plated

Anwendungsbereich & Eigenschaften

For highly wear-resistant deposit welding on wear parts with extreme impact stress and medium abrasive stress; application with machine plants in quarries, rock processing, mining, etc for excavators, conveyor rollers, hammer drills and chisels as well as for cutting tools and moulds for the automotive industry. Further processing by grinding is possible.



Standard identification

| | |
|--------------|--------|
| DIN EN 14700 | S Fe 8 |
| Material No. | 1.4718 |

Chemical composition (standard values/wire analysis in %)

| C | Si | Mn | Cr |
|------|------|------|------|
| 0.45 | 3.00 | 0.40 | 9.20 |

The chemical composition of the pure weld deposit depends on the weld parameters applied.

Mechanical properties (weld deposit, untreated)

| Welding process | Rm (N/mm ²) | Rpo, 2 (N/mm ²) | A5 (%) | Range of hardness DIN EN 14700 (HRC) |
|-----------------|-------------------------|-----------------------------|--------|--------------------------------------|
| MAG/TIG | - | - | - | 57-62 |

The hardness of the weld deposit depends strongly on the degree of melting with the parent metal and its chemical composition. These influencing factors are diminishing with increasing number of layers. Despite its extreme hardness, the weld deposit is tough and crack-resistant.

Instructions for welding: process the weld area in metallic bright condition;
in general, pre-heating with tool steel only to 300°C - 400°C

Weld parameters (shielding gases acc. to DIN EN ISO 14175 : 2008-06)

| Type of process | Shielding gas |
|-----------------|--------------------------|
| MAG | M1, M2, M3 / 18-20 l/min |

| Wire - diameter in mm | Weld current (A) | Weld voltage (V) |
|-----------------------|------------------|------------------|
| 1.20 | 130 - 260 | 26 - 31 |

| | Type of current | Weld positions |
|--------------------|---------------------------|----------------------|
| MAG-wire electrode | direct current (+ pole) | PA PB PF PC PD PE PG |

| Diam. | 15kg Spool |
|-------|------------|
| 1.2mm | EA6001215 |

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