

TOOLFRO

TOP FEATURES

- Good warm hardness and excellent service life.
- Weld metal hardness of ~58HRC in the as-welded condition, it can reach 65HRC after Quench an Temper.
- Weld metal can only be machined by grinding.

CLASSIFICATION

EN 14700 E Z (Fe2)

CURRENT TYPE

DC+

WELDING POSITIONS

Flat/Horizontal

CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, ALL WELD METAL

| C | Mn | Cr | Mo | Fe | V | W |
|-----|----|----|----|------|-----|-----|
| 1.5 | 1 | 4 | 8 | bal. | 1.5 | 2.5 |

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

| Required | Condition* | Hardness (HRC) |
|----------------|------------|----------------|
| EN ISO 14700 | AW | 30-58 |
| Typical values | AW | 58 |

*AW: As-welded

OUTPUT RANGE

| Diameter x Length (mm) | Current range (A) |
|------------------------|-------------------|
| 2.5 x 350 | 80-100 |
| 3.2 x 450 | 135-150 |
| 4.0 x 450 | 180-200 |

PACKAGING AND AVAILABLE SIZES

| Diameter x Length (mm) | Packaging | Electrodes/pack | Net weight/pack (kg) | Item number |
|------------------------|-----------|-----------------|----------------------|-------------|
| 3.2 x 450 | CBOX | 99 | 5.2 | W000380883 |

TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application

Safety Data Sheets (SDS) are available here:



Subject to Change – The information is accurate to the best of our knowledge at the time of printing.
Please refer to www.lincolnelectric.eu for any updated information.