

CORODUR[®] E WZ 60

CLASSIFICATION:

DIN EN 14700
E Fe4

GENERAL CHARACTERISTICS:

Heavy coated AC-weldable electrode with 150 % recovery, designed for hardfacing high-speed steel tools and low alloyed base materials and for reinforcing cutting edges.

The weld metal has good tempering properties and allows heat treatment like other high-speed steels of similar composition.

APPLICATION:

Typical applications: slotting and threading tools, spiral drills, reamers, and milling cutters (for materials over 880 N/mm²)

TYPICAL ALL WELD METAL ANALYSIS (%):

C	Cr	Mo	W	V
0,9	4,5	8,5	2,0	1,5

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

Hardness: 59 – 62 HRc

CURRENT:

= + / ~ 65 V

WELDING POSITIONS:

PA, PB, PC

REBAKING:

1 h, 350 °C + / - 10 °C (if required)