

# ETC PH600 SUPRADUR 600



## MMA Electrodes Hardfacing

SUPRADUR 600 is a semi-thick basic coated rutile MMA electrode which is easy to use. Weld metal hardness ~550-650HV which can be ground. Very good resistance to medium impact. Used for hardfacing carbon steels and low alloy steels. Preheating to 400 °C is always necessary, particularly for large work pieces and deposit a maximum of 3 layers. A tough buffer layer using UNIVERS or SUPRADUR 400 is only required in the case of very crack sensitive base metal. Applications include civil works and mining equipment, shovel teeth, buckets and crawler shoes.

### Classification

EN	14700: E Fe2
DIN	8555: E 2-UM-60

### Chemical analysis (Typical values in %)

C	Mn	Si	Cr	Fe
0.6	1.1	1	2.8	Rem

### All-weld metal Mechanical Properties

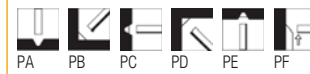
Heat Treatment	Hardness
As Welded	550-650 HV

### Storage

Keep dry and avoid condensation.  
Re-drying not generally required.  
If necessary: 150-200 °C for 2 hours, 5 times max.

### Current condition and welding position

AC; DC-



### Packaging data

Diam. (mm)	Length (mm)	Current (A)	Approx. weight (kg/1000)	BOX	
				PC	Code
3.2	450	85-125	40.7	135	ETC PH60032
4.0	450	100-150	61.6	90	ETC PH60040
5.0	450	150-210	97.5	60	ETC PH60050

