

Thick basic coated MMA electrode for hardfacing rail crossings and rails. Especially suited for switch points of crossings made of bainitic steels. Highly wear resistant. Hardness 48 – 52 HRC (460 – 520 HB).

Weld metal with very low content of diffusible hydrogen (HD ≤ 5 ml / 100 g deposited weld metal).

Vacuumpackaging: no rebaking of the electrodes after opening.

Classification	
EN	14700: ~E Fe1

Approvals	Grade
DB	●

Chemical analysis (Typical values in %)

C	Mn	Si	Cr	Ni	Mo	Fe	V
0.25	0.8	0.6	2.9	0.3	0.4	Rem	0.2


All-weld metal Mechanical Properties

Heat Treatment	Hardness
As Welded	48-52 HRC

Materials

New bainitic steels for heavy duty rail crossings.

Storage
Keep dry and avoid condensation. Re-drying recommended at 340-360 °C for 2 hours, 5 times max.

Current condition and welding position
DC+

PA PB PC

Packaging data

Diam. (mm)	Length (mm)	Current (A)	Approx. weight (kg/1000)	DRYF	
				PC	Code
5.0	450	190-240	105.6	7	●