

SUPRADUR 600RB is a thick rutile coated MMA electrode with good weldability for wear-resistant and tough hard facing. With base plates which are sensitive to welding conditions a tough buffer layer, deposited with TENACITO R or SUPERCHROMAX N is required and for thick facing a buffer layer is required after every third layer. The weld metal is machinable only by grinding. Typical applications include excavator parts, bucket edges, excavator teeth, drilling bits, coal ploughs, conveyor screws, striking tools, crusher jaws and cones.

Classification	
EN	14700: -E Fe2
DIN	8555: E 6-UM-60

Approvals	Grade
DB	●

CE

Chemical analysis (Typical values in %)

C	Mn	Si	Cr	Mo	Fe	V
0.5	0.5	0.8	7	0.5	Rem	0.7

All-weld metal Mechanical Properties

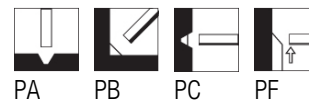
Heat Treatment	Hardness
As Welded	57-62 HRC

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)	CBOX		SMPA	
				PC	Code	PC	Code
2.5	350	65-90	19.2	260	●	35	●
3.2	350	100-130	33.4	155	●	22	●
4.0	350	140-160	47.9	100	●		
5.0	450	160-210	99.5	60	●		