

CLASSIFICATION

DIN 8555 : E6-UM-55 R
EN 14700 : E Fe8

GENERAL DESCRIPTION

L-CR 10 is a basic coated electrode. Wear resistant weld metal has a high toughness value and exhibits a high resistance to cracking at operating conditions with high impact. The highest wear resistance is obtained after three passes. 10 % Cr content increases the wear resistance of the weld metal to the simpler forms of corrosive attack. The weld metal is resistant to softening up to 500°C. It can be machined by grinding.

APPROVALS

GOST, SEPRO, TSE

APPLICATIONS

It is used for hardfacing of alloyed and unalloyed steels. Worn surfaces of crushing tools in the mining industry, conveyor screws, excavator bucket and teeth, excavator and bulldozer blades, mixer parts, screws of cement pumps, and cutting edges of cold worked tool steels can be hardfaced with L-CR 10.

While there is no need to have a buffer layer for unalloyed steels up to St 70; for high alloyed steels, it is recommended to have a buffer layer with L-248 or L-255, and in special cases with L-308Mn or L-312.

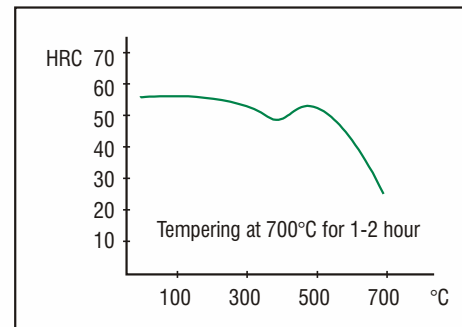
Hardening : in oil or air at 950-1000°C
Softening : in furnace at 850°C

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

C	Si	Mn	Cr
0.70	0.60	0.70	10.00

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Hardness : 52 - 56 HRC



WELDING PARAMETERS / PACKING AND DIAMETER INFORMATIONS / WELDING POSITIONS

Current Type and Polarity : DC (+) ; AC min 65 V

Diameter [mm]	Length [mm]	Current [A]	Electrode Weight [g/100 pcs]	Box Weight [kg] Quantity [pcs/box]	Export Box Weight [kg]
3.25	350	110 - 140	4340	4.8 / 110	5
4.00	450	150 - 190	8410	6.3 / 75	6
5.00	450	180 - 240	13460	6.1 / 45	6



Liability : All information in this data sheet is based on the best available knowledge, is subject to change without notice and can only be considered as suitable for general guidance.
Fumes : Consult information on Welding Safety Sheet, available upon request.

Lion International U.K (M.E.) Limited

Monomark House, 27 Old Gloucester Street, London WC1N 3XX, United Kingdom.
T: +44 20 74198760 F: +44 20 78319489 E: info@lionintweld.co.uk

Lion International Middle East FZC

P.O. Box 41654, W/H No. 1K-01/4, Hamriyah Free Zone, Sharjah, UAE.
T: +971 6 5260461 F: +971 6 5260561 E: info.me@lionintweld.co.uk