

CLASSIFICATION

DIN 8555 : E5-UM-45 R
EN 14700 : E Fe7

GENERAL DESCRIPTION

L-CR 13 is a rutile coated electrode. It gives a corrosion and wear resistant ferritic-mar tensitic stainless steel weld metal. It is used in hardfacing applications where a hardness of 42-46 HRC is required. The weld metal is resistant to softening up to 500°C.

APPROVALS

GOST, SEPRO, TSE

APPLICATIONS

It is used for hardfacing of alloyed and unalloyed steels. Worn surfaces of rails and rail surfaces, crane and conveyor wheels, cast steel valve seats, pinions, track rollers and links of ear thmoving equipment can be hardfaced with L-CR 13. It can also be used for joining of low carbon steels having 13 % Cr.

It is recommended to use L-CR 10 in multipass applications as it is a basic coated electrode. It is also recommended to have a preheating and interpass temperature of minimum 200°C.

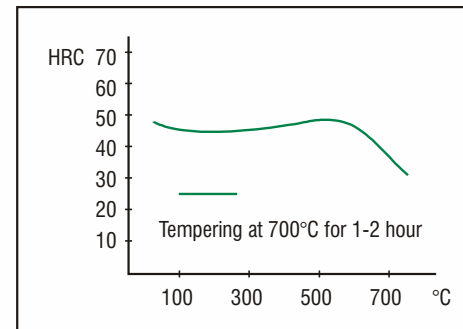
Hardening : in oil or air at 980-1000°C
Softening : in furnace at 780 - 800°C

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

C	Si	Mn	Cr
0.10	0.50	0.30	13.00

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Hardness : 42 - 45 HRC



WELDING PARAMETERS / PACKING AND DIAMETER INFORMATIONS / WELDING POSITIONS

Current Type and Polarity : AC min 70 V ; DC (+)

Diameter [mm]	Length [mm]	Current [A]	Electrode Weight [g/100 pcs]	Box Weight [kg] Quantity [pcs/box]	Export BoxBox Weight [kg]
3.25	350	110 - 160	4640	4.6 / 100	5
4.00	350	140 - 200	6880	4.5 / 65	5
5.00	350	180 - 240	10600	4.8 / 45	5



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