

### CLASSIFICATION

DIN 8555 : E2-UM-60 Z  
EN 14700 : E Fe4

### GENERAL DESCRIPTION

L SD-65 is a basic coated electrode. It gives a high oxidation resistant (up to 850°C) weld metal that also have a high wear resistance. It is resistant to wears of medium abrasions at high temperatures.

### APPROVALS

GOST, SEPRO, TSE

### APPLICATIONS

It is particularly used for repair applications of machine parts that are particularly exposed to wear by stone, coal, sand and soil. Loading machines, band plates, wear plates and parts of grinders can be hardfaced with this electrode. It is recommended to use L SD-65 in high temperature applications where oxidation resistance is more important than hardness and resistance to tempering like feed screws in furnaces.

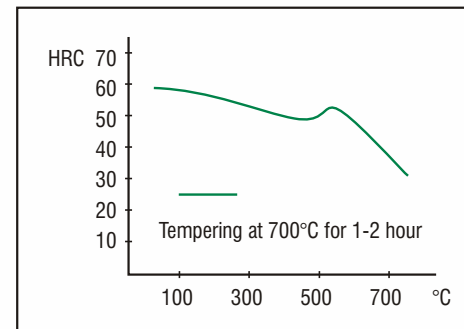
Hardening : in oil or air at 920 - 980°C  
Softening : in furnace at 680 - 700°C

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

C	Si	Mn	Cr
0.70	4.00	0.30	2.00

### MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Hardness : 57 - 62 HRC (3 passes, no preheating)  
50 - 60 HRC (3 passes, 300°C preheating)



### WELDING PARAMETERS / PACKING AND DIAMETER INFORMATIONS / WELDING POSITIONS

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

Diameter [ mm ]	Length [ mm ]	Current [ A ]	Electrode Weight [ g/100 pcs ]	Box Weight [ kg ] Quantity [ pcs/box ]	Export BoxBox Weight [ kg ]
3.25	350	100 - 140	3370	4.7 / 140	5
4.00	450	150 - 180	6660	6.3 / 95	6
5.00	450	180 - 225	9790	6.4 / 65	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.

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