

CLASSIFICATION

DIN 8555 : E10-UM-60 G AWS A5.13 : E FeCr-A1
EN 14700 : E Fe15

GENERAL DESCRIPTION

L SD-Cr is a basic coated electrode that is highly resistant to abrasion wear caused by coarse hard minerals. It has a highly concentrated chromium carbide in its structure.

APPROVALS

GOST, SEPRO, TSE

APPLICATIONS

Bucket conveyors, extruder screws, dragline buckets, dredgers, scrapers, screw conveyors, press screws, heads in ceramic industry, mixer blades and grinding rollers can be hardfaced with L SD-ABRA Cr.

It should not be used for more than three passes. Interpass temperature should be 300-500°C.

In applications requiring a thick deposit metal, L P-308Mn or L P-312 should be used for buffering. It is crucial to have a buffer layer with AS P-308Mn for 12-14 % Mn containing steels before hardfacing applications.

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

C	Cr
4.50	33.00

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Hardness	: 58 - 62 HRC
Carbide hardness	: 1400 - 1500 HV

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 BoxBox Weight [kg]
3.25	350	115 - 160	5760	4.6 / 80	5
4.00	350	120 - 190	9140	4.6 / 50	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.

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