

## CLASSIFICATION

DIN 8555 : E4-UM-60 (65) S  
EN 14700 : E Fe4

## GENERAL DESCRIPTION

L SD-HSS is a basic coated electrode. It gives a Mo alloyed, high speed steel type weld metal. Deposited metal retains its toughness proper ties at high temperatures enabling the formation of high strength welds, particularly during the hardfacing of cutting and punching tools.

## APPROVALS

GOST, SEPRO, TSE

## APPLICATIONS

It is particularly used for hardfacing of cutting and punching tools made of alloyed and unalloyed steels with a hot tool steel structured weld metal. Part that is going to be welded should be preheated to 400-500°C and small beads should be preferred to inhibit overheating.

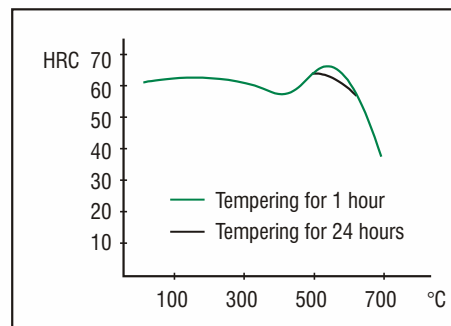
Machine tools, drilling parts, and tools made of high speed steels are among other application areas.

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

C	Si	Mn	Cr	Mo	W	V
0.90	1.20	1.30	4.50	7.50	1.80	1.50

## MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Hardness : 57 - 60 HRC (as welded)  
65 HRC (after double tempering)



## 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 ]
2.50	350	70 - 100	2580	2.1 / 80	5
3.25	350	100 - 140	4370	2.2 / 50	5
4.00	350	150 - 185	6680	2.0 / 30	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.