

Classifications

DIN 8555	EN 14700
E 10-UM-65-GR	E Z Fe 15

Characteristics and typical fields of application

WEARstick XD 63 is used for hardfacing of parts subject to heavy abrasion with moderate impact, i.e. cement presses, brick presses, refractory press-screws, conveyor screws, mixer blades, palm-nut etc.

Service temperature up to 450 °C.

WEARstick XD 63 has a quiet and regular drop transfer, can be welded in flat and vertical-up position. 190 % recovery. Stable arc, easy slag removal. Machining by grinding only.

Hardness of the pure weld deposit:

1. layer: 62 HRC
2. layer: 63 HRC

Typical analysis

	C	Si	Mn	Cr	Nb	Fe
wt.-%	6.5	1.5	1.5	24.5	7.0	bal.

Operating data

	Polarity	DC + / AC	Dimension mm	Current A
	Redrying	1 h / 300°C	3.2 × 350	110 - 140
			4.0 × 450	140 - 190
			5.0 × 450	190 - 250

Hold the electrode vertically and keep a short arc, prepare the welding zone by polishing to metallic blank. For multi-layers, a buffer layer with UTP 630 is recommended. Re-drying: 1 hour at 300 °C.

Approvals

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