

## Classifications

<b>AWS A5.13 / SFA-5.13</b>	<b>DIN 8555</b>	<b>EN 14700</b>
EFeCr-A8 (mod.)	E 10-UM-60-GRZ	E Fe14

## Characteristics and typical fields of application

WEARstick XD 61 is suited for highly wear resistant claddings on parts subject to strong grinding abrasion combined with medium impact, such as conveyor screws, scraper blades, bucket teeth, mixer wings, sand pumps. Also as a final layer on crusher jaws.

WEARstick XD 61 has excellent welding characteristics and a very easy slag removal. The homogeneous and finely rippled seam surface does, for most applications, not require any finishing by grinding.

Hardness of the pure weld deposit: approx. 60 HRC

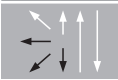
1 layer on steel with C = 0,15 %: approx. 55 HRC

1 layer on high Mn-steel: approx. 52 HRC

## Typical analysis

	C	Si	Cr	Fe
wt.-%	3.2	1.3	32.0	bal.

## Operating data

	<b>Polarity</b>	DC + / AC	<b>Dimension mm</b>	<b>Current A</b>
	<b>Redrying</b>	2h / 300° C	2.5 × 350	80 – 100
			3.2 × 350	90 – 130
			4.0 × 450	130 – 180
			5.0 × 450	140 – 190

## Welding instructions

Hold stick electrode as vertically as possible, keep a short arc. For multipass applications a cushion layer with UTP 630 is recommended. Redry stick electrodes that have got damp for 2h / 300 °C.

## Approvals

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