# CARBODUR 59

| | | |
|---|---|---|
| **Standards** | DIN 8555 | E 10-UM-60-GR |
| | AWS A5.13 / 21 | EFeCr-A1 |

**Approvals** ---

**Characteristics** CARBODUR 59 is a heavy coated high efficiency hardfacing electrode with 160 % recovery. Suitable for applications subject to strong abrasive wear by minerals, combined with moderate impact, medium shocks and compression as well as humidity or wetness.
Soft fusion, fin-structured seam surface, self-releasing slag and a shiny surface of deposits

**Typical applications** Mainly used on pump bodies, mixer blades, agitator arms, concrete pumps, and conveyer worms, crushing and pulverizing plants, bucket teeth and coke-oven slides.

**Operating temperature**

**Hardness of all-weld metal ( typical values)**

| HRc |
|---|
| ca. 59 |

**Weld metal analysis** (typical, wt. %)

| C | Si | Cr | Others |
|---|---|---|---|
| 3,8 | 0,9 | 33 | approx. 2 |

**Current** = + / ~ 50 V

**Welding positions** PA, PB

**Rebaking** 1 h, 350°C + / - 10 °C ( if required)

| Dia./Length | Amperage (A) | Pcs./ packet | Pcs./ carton | kg / 1000 | kg / packet | kg / carton |
|---|---|---|---|---|---|---|
| 2.5 x 350 | 70 - 110 | 159 | 637 | 31.4 | 5.0 | 20.0 |
| 3.2 x 350 | 90 - 130 | 94 | 377 | 53.1 | 5.0 | 20.0 |
| 4.0 x 450 | 120 - 160 | 58 | 232 | 103.4 | 6.0 | 24.0 |
| 5.0 x 450 | 150 - 230 | 37 | 149 | 161.5 | 6.0 | 24.0 |
| 6.0 x 450 | 180 - 260 | 26 | 103 | 232.6 | 6.0 | 24.0 |

Rev. 000