

Repair electrode

Classification

AWS A5.11M :ENiCrMo-5*
 DIN 8555-83 :E23-UM-200-CKPTZ

* Nearest classification

General Description

Rutile coated stick electrode for hardfacings on machine components and tools subjected to corrosion and heat.
Weld deposit rate 170%.
Weld metal comprises low iron nickel-chromium-molybdenum-tungsten-alloy.
Smooth stable arc.
Low dilution with the parent material.
Slag easily removable.

Welding positions



ISO/ASME PA/1G PB/2F

Current type

AC/DC electr. +

Chemical composition (w%), typical, all weld metal

C	Mn	Si	Cr	Ni	Mo	W	Fe
0.02	0.9	0.9	16	rest	17	4.0	6.5

Mechanical properties, all weld metal

Typical hardness values	
As deposited	225HB
Work hardened	400HB

Packaging, available sizes and identification

	Diameter (mm)	3.2
	Length (mm)	350
Unit:	Pieces / unit (nominal)	40
Box	Net weight (kg)	2.5

Identification

Imprint: Elerep[®]NiCrMo

Tip colour: violet

Elerep[®]NiCrMo: rev.EN 20

Materials to be welded

Hardfacings on new or damaged hot working tools, such as: forging dies, forging saddles, hot-shearing blades, hot-trimming dies (applicable at high temperatures)

Calculation data

Sizes Diam.x length (mm)	Range of current (A)	Type of current	Arc time - per electrode at max. current - (s)*	Energy E (kJ)	Dep. rate H (kg/h)	Weight/ 1000 pcs. (kg)	Electrodes/ kg weldmetal (pcs)	kg Electrodes/ kg weldmetal (1/N)
3.2x350	110-140	-	-	-	-	59	-	-

*stub end = 35 mm

Welding parameters,optimum fill passes

Welding position Diameter (mm)	PA/1G Current (A)	PB/2F	PC/2G	PF/3G up	PE/4G	PF/5G up
3.2	120					

Remarks

In the case of great hardfacing thicknesses, fill beforehand with Elerep[®] 312

Application advice

Untreated weld metal machinable