

DURMAT[®] E-PLUS

**Stick Electrode DIN EN 14700: E Fe20
(DIN 8555: E21-GF-UM-60-CG)**

General characteristics:

DURMAT E-PLUS is a tube metal filled with spherical fused tungsten carbide (SFTC) developed for manual application. This electrode can be applied by alternating or direct current trouble free once the proper machine setting is obtained.

Application:

For hard facing unalloyed and low alloyed steels (cast steels) with a maximum carbon content of 0.45%. Higher carbon content could lead to cracking. For welding on most high alloyed steels after a buffer layer is recommended. Also for hard facing tools and machine parts that are exposed to wear in mining, excavation, digging, road construction and deep drilling applications.

Physical characteristics:

Hardness: 55 – 58 HRC

Welding recommendation:

Type	Ø mm	Ø inch	length of rod	Amps	Voltage
3505	3.5	1/8	350 mm	90 A	= + / ~
4005	4.0	5/32	350 mm	110 A	= + / ~
5005	5.0	3/16	350 mm	140 A	= + / ~
6005	6.0	1/4	350 mm	160 A	= + / ~
8005	8.0	5/16	350 mm	200 A	= + / ~

Depending on the base metal's alloy and the area to be hard faced, a preheating temperature between 350-500°C (662-932°F) is advised.

NOTE: Since DURMAT E-PLUS is a hollow tube metal filled with fused tungsten carbide powder, the lowest amp setting possible should be used when depositing it in order to avoid any damage to the carbides.