



CEWELD E DUR 64

TYPE	Basic coated, high Chromium-Niobium based Hardfacing high recovery hardfacing electrode								
APPLICATIONS	CEWELD® E DUR 64 with a recovery 190% can be used for coverings with extreme abrasion and sliding wear resistance, but with medium impact resistance.								
PROPERTIES	Due to the high Mo-content, abrasion resistance can be kept up to working temperatures of 600 °C ; the hardness is still 40-45 HRc at these temperatures. For Hardfacing of more than 3 layers it is necessary to buffer with an electrode like CEWELD® E DUR 350 Kb that delivers a welding deposit of less hardness. Overlays on steel with high tensile strength have to be buffered with CEWELD® 29/9 S or CEWELD® 4370 Ti Equivalent in FCAW: CEWELD® OA 64								
CLASSIFICATION	AWS	A 5.13: E FeCr-E4							
	EN ISO	14700: E Fe16							
	DIN	8555: E 10-UM-65- GTZ							
	F-nr	71							
SUITABLE FOR	Sugar mill knives and Hammers, Clinker crushers, Sintering lines, Fire gratings, Mixer blades, Gravel washing equipment, Ceramic mixer blades, Mill rollers, Stone crushers, Cxtruders etc....								
APPROVALS									
WELDING POSITIONS									
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	C	Mn	Cr	Mo	Nb	V	Fe	W	Si
	5.5	0.6	24	6	6	1	Rem.	2	0.9
MECHANICAL PROPERTIES	Heat Treatment		R _{P0,2} (MPa)		R _m (MPa)		A5 (%)	Hardness	
	As Welded							61 HRc	
REDRYING	300°C / 2 hr								
GAS ACC. EN ISO 14175									



CEWELD E DUR 64

E DUR 64 3,2 X 350MM

Packaging	KG/unit	EanCode
Can	2,4	8720663402677

E DUR 64 4,0 X 450MM

Packaging	KG/unit	EanCode
Can	3,0	8720663402684

E DUR 64 5,0 X 450MM

Packaging	KG/unit	EanCode
Can	2,9	8720663402691