



Elgaloy Hard M60

REPAIR & MAINTENANCE

Other

Date: 06/13/2013
Revision: 1

Description:

Elgaloy Hard M60 is a solid wire producing a martensitic weld metal with a hardness of 55-60 HRC. The deposit exhibits a good wear resistance under conditions of abrasion and friction coupled with moderate impact and can be shaped by grinding.

Applications:

Excavator teeth, bulldozer blades, swing hammers, crusher jaws, scrapers etc.

Wire composition, wt. %

	C	Si	Mn	P	S	Cr
Min						
Typical	0,45	2,95	0,35	0,025	0,002	9,20
Max						

Shielding gas:

M21, Ar + 15-25% CO₂, 7-12 l/min

Hardness as welded:

55-60 HRC

Welding current:

DC+

Classification:

EN 14700

S Fe8

Approvals:

Note

With shielding gas M21.
Machinability: grinding only.

Product data:

Dim.mm	Product code	Current A	Voltage V	Delivery form
1,00	7031-1040	180-240	24-28	15kg K300
1,20	7031-1240	220-320	26-32	15kg K300
1,60	7031-1640	282-460	28-38	15kg K300