

ES 260

Type Basic

SMAW

E 2-UM-60

ESWECO
The Art of Welding

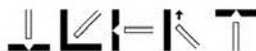
Description

ES 260 deposits a hard, wear-resistant weld metal. Good resistance to oxidation up to about 875°C. Suitable for hardfacing machine parts exposed to wear from stone, coal, sand and soil. Typical applications are dredging machines, feeder screws, Crusher and tractor parts.

It is recommended to use ES 260 in high temperature applications where oxidation resistance is more important than hardness and resistance to tempering like feed screws in furnaces

Current

AC, DC+ OCV 70 V



Classifications

DIN 8555 E 2-UM 60

Typical all weld metal composition, %

C	Cr	Si	Mn
0.8	2.0	4.0	<0.6

Typical mech. Properties all weld metal

Weld metal hardness, a w

No preheat, interpass temperature 60°C:	58-63 HRC
Preheat and interpass temperature 300°C:	56-60 HRC
Machinability	Grinding only
Abrasion resistance	Very good

Tempering resistance

Temp°C/1h	HRC
100	61
200	60
300	59
400	56
500	58
600	55
700	41

Welding parameters

Diameter, mm	Length, mm	Welding current, A	Arc voltage, V
3.2	450	100-140	23
4.0	450	140-190	25
5.0	450	190-260	26