

ES 600

Type Basic

SMAW

E 6-UM-60-S

ESWECO
The Art of Welding

Description

ES 600 is a basic hardfacing electrode designed for applications in which heavy abrasive wear or a combination of abrasive and impact wear are present.

Typical applications include rock- crushing machinery parts and drilling equipment, block presses, crusher jaws, wheel rims, rollers, caterpillar tracks, ploughshares, running surfaces, cutting edges etc.

Steel with carbon over 0.4 % must be preheated between 200-300 °C and cooled slowly after welding.

Current

DC+



Classifications

EN 14700	E Fe8
DIN 8555	E 6-UM-60-S

Typical all weld metal composition, %

C	Si	Mn	Cr
0.05	2.2	0.4	10.0

Typical mech. Properties all weld metal

Hardness, HRC 55-62

Welding parameters

Diameter,mm	Length,mm	Welding current, A	Arc voltage,V
3.2	450	110-140	30
4.0	450	150-190	31
5.0	450	190-260	32