

# Wearshield® 50MC

## Hardfacing electrode

### Classification

DIN 8555 : E10-UM-65-GRZ  
EN 14700 : E Fe16

### General description

Basic coated electrode for hardfacing with an efficiency of about 200%  
Extreme resistance against abrasion up to temperatures of 700°C

### Application

Typical APLs include:  
Ore-crushers, ore chutes, hot slag crushers, dragline teeth, diggers, etc.



### Mechanical properties, all weld metal

Typical hardness values

1 Layer 62-67 HRC  
Welded on Mild Steel Plate

### Packaging and available sizes

	Diameter (mm)	3.2	4.0
	Length (mm)	350	350
Unit: Box	Pieces / unit	41	27
	Net weight/unit (kg)	2.5	2.5

### Identification

Imprint: WEARSHIELD 50 MC

Tip Color: white

Wearshield® 50MC: rev. EN 22

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## Additional information

By preference, weld under inclined angle of 20 degrees.

Weave during welding in a width of approx. 50 mm.

During solidification small cracks will occur.

These cracks, however, will have no detrimental effect on the weld metal properties regarding its abrasive wear resistance.

A maximum of two layers should be applied to prevent the weld from braking out.

## Welding positions



ISO/ASME PA/1G PF/3Gup

## Current type

AC / DC +

## Chemical composition (w%), typical, all weld metal

C	Mn	Cr	Nb	W	V	Si	B
5	2	21	6.4	3.1	0.7	2.1	0.8

## Structure

Supereutectic + primary carbides.

## Calculation data

Sizes Diam. x length (mm)	Current range (A)	Current type	Arc time - per electrode at max. current - (s)*	Energy E(kJ)	Dep.rate H(kg/h)	Weight/ 1000 pcs. (kg)	Electrodes/ kg weldmetal B	kg Electrodes/ kg weldmetal 1/N
3.2 x 350	120 - 160	DC+	156	699	1.28	67	18	1.21
4.0 x 350	160 - 200	DC+	172	1011	1.50	100	14	1.40

## Complementary products

Complementary products include flux cored wire Lincore® 65-O.