

## UN-D102 Surfacing Welding Electrodes 堆焊焊条

**Standard:** GB-EDPMn2-03

**Description:** D102 is ordinary manganese type electrode with Titanium-calcium coating for surfacing welding. Arc is stable and slag is easy to remove, it can be operated on both AC and DC.

**Chemical composition of weld metal(%):**

C	Mn
≤0.20	≤3.5

**Recommended current:**

Weld rod diameter (mm)	3.2	4.0	5.0
Welding current (A)	90-110	140-180	180-220

**Hardness of surfacing weld Layer:HRC≥22**

Size(mm)	3.2X350	4.0×400	5.0X450
Per Box(kgs)	5	5	5
Boxes/Carton	4	4	4
Per Carton(kgs)	20		

**PACKING**

## Surfacing Welding Electrodes 堆焊焊条

Model Name	Standard (GB)	Chemical composition	HRC	Description
<b>UN-D107</b>	EDPMn2-15	C≤0.20 Mn ≤3.50	≥22	D107 is ordinary manganese type electrode with Low hydrogen coating for surfacing welding. It can be operated on DC reversed.
<b>UN-D112</b>	EDPCrMo-A1-03	C ≤0.25 Mo ≤1.50 Cr≤2.00 other element≤2.0	≥22	D112 is chromium-molybdenum type electrode with Titanium-calcium coating for surfacing welding. Arc is stable and slag is easy to remove, it can be operated on both AC and DC.
<b>UN-D167</b>	EDPMn6-15	C ≤0.45 Mn ≤6.50 Si≤1.00	≥50	D167 is manganese-silicon type electrode with Low hydrogen coating for surfacing welding. It can be operated on DC reversed.
<b>UN-D132</b>	EDPCrMo-A2-03	C ≤0.50 Cr ≤3.00 Mo≤1.50	≥31	D132 is chromium-molybdenum type electrode with Titanium-calcium coating for surfacing welding. Arc is stable and slag is easy to remove, it can be operated on both AC and DC.
<b>UN-D207</b>	EDPCrMnSi-15	C 0.50-1.00 Mn≤2.50 Cr ≤3.50 Si≤1.00 other element≤1.0	≥50	D207 is chromium manganese-silicon type electrode with Low hydrogen coating for surfacing welding. It can be operated on DC reversed.
<b>UN-D608</b>	EDZ-AI-08	C 2.50-4.50 Cr 3.00-5.00 Mo 3.00-5.00	≥55	D608 is chrome-molybdenum cast iron type electrode with tungsten coating for deposited welding. It can be operated on both AC and DC, but operating on DC is better. Since the weld metal consists of Chrome-molybdenum carbide,so surfacing layer provided with more hardness and anti-abrasion ability. It has excellent anti-abrasion ability to sand and ore.