

Hardfacing Welding Electrode

This hardfacing welding electrode is designed for surfacing and repair welding of worn parts. It is suitable for different welding positions and current types.



ADDITIONAL IMAGES

WELDING ELECTRODE		WELDING ELECTRODE	
HARDFACING WELDING ELECTRODE			
Model	MT-HF60CR2	Model	MT-HF60CR2
Material	Cr-Mn-Ni	Material	Cr-Mn-Ni
Hardness	HRC 58-62	Hardness	HRC 58-62
Application	Hardfacing	Application	Hardfacing
Position	F, V, OH, H, HF	Position	F, V, OH, H, HF
Current	AC, DC+	Current	AC, DC+
Diameter	2.5, 3.2, 4.0, 5.0 mm	Diameter	2.5, 3.2, 4.0, 5.0 mm
Length	350 mm	Length	350 mm
Weight	2.5 kg	Weight	2.5 kg
Storage	Dry, 300-350°C	Storage	Dry, 300-350°C
Manufacturer	Merhein	Manufacturer	Merhein



Overview

Professional Hardfacing Solutions

These hardfacing welding electrodes are engineered for the surfacing and repair of worn industrial components. Designed to enhance durability and wear resistance, they are suitable for a wide range of applications including mining machinery, agricultural equipment, and heavy-duty structural steel. Available in various chemical compositions and hardness levels, these electrodes offer versatile performance for diverse maintenance and manufacturing needs.

Technical Specifications

Available Diameters

- 2.5 mm
- 3.2 mm
- 4.0 mm
- 5.0 mm

Preparation Guidelines

To ensure optimal weld quality, electrodes should be kept dry. Before use, it is recommended to dry the electrodes at 300-350°C for 30-60 minutes.

Welding Positions

F (Flat), V (Vertical), OH (Overhead), H (Horizontal), HF (Horizontal-Fillet)

Compatible Current Types

AC, DC+

Packaging & Logistics

Packaging Information

20kg net cartons (8 boxes x 2.5kg for 2.5mm size; 4 boxes x 5kg for other sizes). Palletized or non-palletized shipping options available.

Performance Data

WELDING ELECTRODE

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Item Code	Type	Equivalent EN	Tensile Strength	Yield Strength	Elements & Trace Elements					Chemical Composition (%)					Notes			
					C	Mn	P	S	Si	Cr	Ni	Mo	W	Co		Al	Fe	
MT-112	Carbon	EN 10025 S235	355	235	0.25	0.35	0.015	0.010	0.03	0.05	0.05	0.05	0.05	0.05	0.05	0.05	0.05	Repair of low/medium carbon and low alloy steel
MT-132	Carbon	EN 10025 S275	355	275	0.25	0.35	0.015	0.010	0.03	0.05	0.05	0.05	0.05	0.05	0.05	0.05	0.05	Repair of low/medium carbon steels
MT-172	Carbon	EN 10025 S355	355	355	0.25	0.35	0.015	0.010	0.03	0.05	0.05	0.05	0.05	0.05	0.05	0.05	0.05	Gear wheels, mining machinery
MT-212	Carbon	EN 10025 S460	355	460	0.25	0.35	0.015	0.010	0.03	0.05	0.05	0.05	0.05	0.05	0.05	0.05	0.05	Excavator and gear parts
MT-256	Carbon	EN 10025 S500	355	500	0.25	0.35	0.015	0.010	0.03	0.05	0.05	0.05	0.05	0.05	0.05	0.05	0.05	Crushers, rails, bulldozers
MT-322	Carbon	EN 10025 S690	355	690	0.25	0.35	0.015	0.010	0.03	0.05	0.05	0.05	0.05	0.05	0.05	0.05	0.05	Cutting tools and high-wear mechanical parts
MT-707	Carbon	EN 10025 S700	355	700	0.25	0.35	0.015	0.010	0.03	0.05	0.05	0.05	0.05	0.05	0.05	0.05	0.05	Concrete mixer vanes, rock-wear resistant parts

Detailed technical specifications and application guide for our hardfacing electrode range.

Electrode Performance & Application

Item Code	Hardness (HRC/HB)	Primary Application
MT-112	HBe220	Repair of low/medium carbon and low alloy steel
MT-132	e30HRC	Repair of low/medium carbon steels
MT-172	e40HRC	Gear wheels, mining machinery
MT-212	e50HRC	Excavator and gear parts
MT-256	HBe170	Crushers, rails, bulldozers
MT-322	e55HRC	Cutting tools and high-wear mechanical parts
MT-707	e60HRC	Concrete mixer vanes, rock-wear resistant parts