



# CEWELD E DUR 1U

|                |                                                                                                                                                                                                                                                   |                                                                |  |
|----------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------------------------------------------------------|--|
| TYPE           | Cobalt-based thermo shock resistant alloy for overlay applications.( Stellite 1, CoCr-C, E Co3)                                                                                                                                                   |                                                                |  |
| APPLICATIONS   | CEWELD® E DUR 1U is typically used for cutting tools that need to withstand abrasion, heat and corrosion.<br>Examples of uses include: Industrial knives for cutting carpets, plastics, paper, synthetic fibers and saw tips in the wood industry |                                                                |  |
| PROPERTIES     | CEWELD® E DUR 1U has excellent properties against severe abrasion, erosion and corrosion in high temperature environments (900 °C). This electrode is also ideal for applications that are subject to high friction.                              |                                                                |  |
| CLASSIFICATION | AWS<br>EN ISO<br>DIN<br>F-nr                                                                                                                                                                                                                      | A 5.13: E CoCr-C<br>14700: E Co3<br>8555: E 20-UM-55-CTZ<br>71 |  |
| SUITABLE FOR   | 53-55 HRc, Stellite 1 alloy with high resistance to abrasion, oxidation and erosion, metal to metal friction and wear, heat resistant, high hardness at high temperatures, completely tempering resistant                                         |                                                                |  |

## APPROVALS

## WELDING POSITIONS



## TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

| C   | Si  | Mn  | Fe  | W  | Cr | Co   |
|-----|-----|-----|-----|----|----|------|
| 2.4 | 0.7 | 0.4 | 2.5 | 11 | 30 | Rem. |

## MECHANICAL PROPERTIES

| Heat Treatment | R <sub>P0.2</sub> (MPa) | R <sub>m</sub> (MPa) | A5 (%) | Hardness |
|----------------|-------------------------|----------------------|--------|----------|
| As Welded      |                         |                      |        | 55 HRc   |

REDRYING Not required

GAS ACC. EN ISO 14175