

## EC160

**EC160** is a high chromium, high carbon welding wire for hard surfacing components, and undertaking repairs of onto a base plate utilising submerged arc welding to achieve a wear resistant plate for use in a variety of material handling applicationsexisting weld overlay plate.

### OPERATIONAL CHARACTERISTICS / WELDING PARAMETERS

<b>Diameter:</b>	1.6mm
<b>Current:</b>	150 – 350 AMPS (Optimum 270 AMPS)
<b>Wire Feed Speed:</b>	4 – 8 metres per minute
<b>Voltage:</b>	24 – 28 (Optimum – 24mm)
<b>Stick-out:</b>	25-50mm (Optimum 25mm)
<b>Shielding Gas:</b>	None required

### PREHEAT / INTERPASS TEMP

For general use, area to be hardfaced does not require preheat

### SPECIFICATION

ECI60 overlay has been manufactured to ensure compliance with AS/NZS 2576:2005 Grade 2355.

### TYPICAL PROPERTIES

<b>Bulk Hardness:</b>	>630 HV30 (~57 HRC)
<b>Primary M<sub>7</sub>C<sub>3</sub> carbide:</b>	~1500 HV <sub>0.5</sub>
<b>Volume fraction Primary Carbides:</b>	20% to 40%

### WELDING

The base material can be welded with standard low hydrogen welding consumables. (Avoid contact with overlay material)

### CUTTING, FORMING AND FABRICATION

Plasma cutting is the recommended method for cutting **ECI60**. The mild steel backing plate provides **ECI60** with structural integrity, thus allowing entire structures to be fabricated from **ECI60**.

### BENEFITS

- Welding into position is made easy due to mild steel base.
- Proven performance against Q&T Steels
- Excellent wear properties of casting
- Readily formed into almost any shape mild steel can.

### APPLICATIONS

Applications involving severe sliding abrasion and medium impact, such as:

- Wear plate repairs
- Fan blades
- Excavator bucket protection
- Stackers
- Mobile Plant
- TLO Systems
- Hoppers
- Screen decks
- Spill plates



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