

WEARstick Dur 600

Universal basic stick electrode for multi-purpose wear protection

Product features	User benefits
» All-weld metal hardness 56-58 HRC	» Long lasting protection of surface exposed to abrasion, compression and impacts » Crack-free weld overlay even in multilayer deposit » Machinable by grinding or with tungsten carbide tools
» Stable arc » Weldable in all positions except vertical down	» Easy electrode handling » Reduced spatters » Perfect tool for on-site repairs

WEARstick Dur 600 , the classic universal hardfacing stick electrode, is designed for cladding on parts of steel, cast steel and high Mn-steel, subject simultaneously to abrasion, impact and compression.

Containing 0.5% carbon, 9% chromium, this alloy delivers a combination of excellent wear resistance and good toughness, even under harsh conditions. Its optimized chemistry ensures high hardness and extended service life, reducing downtime and maintenance costs.



Typical applications

- » Earth movers
- » Bucket and bucket teeth
- » Recycling
- » Hammer crushers
- » Agriculture
- » Repair of cutting tools

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Classifications			Approvals
EN 14700	Welding positions	Polarity	
E Fe 8		DC+ / AC	DB (No. 20.014.23)

Typical analysis in %				
C	Si	Mn	Cr	Fe
0.5	2.3	0.4	9.0	balance

Hardness			
All-weld metal As welded	All-weld metal After soft annealing	1 st Layer on High Mn steel	2 nd Layer on High Mn steel
56-58 HRC	54-60 HRC	22 HRC	40 HRC

Recommended welding parameters	
Electrodes Ø x L [mm]	Amperage [A]
2.5 x 350	80 - 100
3.2 x 450	100 - 130
4.0 x 450	140 - 180
5.0 x 450	180 - 210

Packaging				
Carton boxes	Dimension (diameter x length)	Weight in kg	Pieces (approx.)	Item number
	3.2 x 450 mm	5.8 kg	130	11000
	4.0 x 450 mm	5.0 kg	90	11001
	Other dimensions available on request			