

WEARstick XD 61

Rutile-basic coated hardfacing stick electrode

Product features	Customer benefits
» High Chromium carbide weld overlay » High hardness of 60HRC	» High resistance to abrasion combined with medium impacts
» High recovery electrode (160%)	» Increased deposition rate and productivity
» Rutile – basic coating	» Excellent welding behavior » Easy slag removal - no need for grinding

WEARstick XD 61 is a rutile coated hardfacing electrode designed for applications requiring high abrasion resistance combined with medium impacts.

The all-weld metal achieves a hardness of approximately 60 HRC and contains chromium carbides that provide outstanding wear protection, particularly in highly abrasive environments.

WEARstick XD 61 offers excellent welding characteristics, including very easy slag removal. The resulting weld surface is homogeneous with finely rippled appearance, and in most cases requires no post-weld grinding.

Stress relief cracks may appear in the weld overlay; these are normal and do not affect performance.



Typical applications

- » Conveyor screws
- » Scraper and mixer blades
- » Bucket teeth and digging teeth
- » Sand pumps
- » Final layer on crusher jaws

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Classifications		
AWS A5.13 / SFA-5.13	DIN 8555	EN 14700
EFeCr-A8 (mod.)	E 10-UM-60-GRZ	E Fe14

Typical chemical composition, all weld metal, wt. %			
C	Si	Cr	Fe
3.2	1.3	32.0	balance

Welding Instructions
Hold stick electrode as vertically as possible, keep a short arc. For multi-pass applications a buffer layer with UTP 630 is recommended to prevent hardening cracks in the weld deposit. Redry stick electrodes for 2h / 300 °C.

Typical Hardness		
Pure Weld Deposit	1 layer on steel with C = 0,15 %	1 layer on high Mn-steel
approx. 60 HRC	approx. 55 HRC	approx. 52 HRC

Packaging				
Carton boxes	Dimension in mm Diameter x Length	Weight in kg	Pieces (approx.)	Item number
	3.2 x 350	4.0	80	61784
	4.0 x 450	5.2	55	61785

Other dimensions or packaging available on request