



FUSION™ 600 E, a hardfacing electrode, is an excellent option for carbon and low alloy steels, cast iron and manganese, bonding readily to all. It is intended for applications with impact and abrasion resistant qualities, being the optimum choice to the combination. The deposits take a high polish, contributing the wear qualities, and applies well out of position.

Typical Deposit Characteristics

Abrasion Resistance	Excellent
Impact Resistance	Moderate
Compressive Strength	Very High
Hardness	HRC 57 – 61
Hot Hardness Temperature	Up to 1,000°F
Magnetic	
On Carbon Steel	No
On Manganese Steel	No
Surface Cross Checks	Yes
Machinability	No
Deposit Layers	Up to 3

Operational Characteristics/Welding Parameters

Diameter	5/32" (4.0mm)	OR	1/8" (3.2mm)
Current, Amp. CC DC+	140 – 170	OR	90 – 120
Position	All		
Length	14"		

Alloy Type

Primary Chromium Carbides in an Austenitic Matrix

Typical Applications

- Jaw Crushers
- Hammers
- Mill Hammers
- Bucket Teeth
- Edges
- Crusher Rolls

Standard Sizes & Packaging

Diameter: 5/32" (4.0mm) OR 1/8" (3.2mm)
 Packaging: 10 lbs. Vac Pack