

CORODUR[®] 240 K

CLASSIFICATION:

DIN EN 14700 DIN 8555
T Fe9 MF 7-200-KNP

GENERAL CHARACTERISTICS:

The flux-cored wire electrode is suitable for welding parts of manganese steel ("Hadfield" type), which are exposed to high impact wear and tear. The non-magnetic austenitic deposit is tough, crack-free and work hardening. The Weld process should be adjusted as cold as possible due to grain growth and embrittlement at higher temperatures of 400°C.

Typical applications can be found in the rebuilding of crusher jaws, railroad components, bucket teeth and lips, and it is designed for reclaiming worn parts of manganese base material.

APPLICATION:

Crushers, swing hammers, railway crossings, dredger buckets

TYPICAL ALL WELD METAL ANALYSIS (%):

C	Si	Mn	Cr	Ni
1,1	0,3	14,0	4,0	0,6

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

Hardness pure weld metal: 200 - 230 HB

Work hardened: 450 HB

PARAMETER:

Dia.	Voltage	Amps
1,2	20 - 24	150 - 200
1,6	22 - 26	180 - 240
2,0	25 - 27	220 - 260
2,4	25 - 27	260 - 300
2,8	26 - 28	280 - 340

FORMS OF DELIVERY:

Coil "BS 300" = 15 kg | Coil "BS 450" = 25 kg | Drums = 300 kg

OA = gasless, G = gas shielded, SA = Submerged Arc