

CORODUR[®] 250 K

CLASSIFICATION:

DIN EN 14700 DIN 8555
T Fe9 MF 7-250-KNP

GENERAL CHARACTERISTICS:

CORODUR 250 K is a highly Mn- Cr- alloyed flux-cored wire. The fully austenitic weld material has high plasticity and acts as a plastic buffer. Deposits have a work hardening up to 500 HB, are stainless and not magnetic. CORODUR 250 K is suitable for welding buffer layers before welding over old hardfacings, because it deposits a ductile weld metal. The deposit resists high shrinkage stresses and impact loadings .

APPLICATION:

Repair of: manganese steel buckets and shovels, high tensile tools , mill-shafts , clutches, crane wheels, earthmoving undercarriage parts, gear wheels , Crusher , rails and crossovers , buffer layers

TYPICAL ALL WELD METAL ANALYSIS (%):

C	Si	Mn	Cr	Ni	Mo	V
0,5	0,4	16,0	14,0	1,2	0,5	0,2

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

Hardness: 220 – 250 HB
Work hardened: up to 500 HB

PARAMETER:

Diameter	Voltage	Amps
1,2	18 - 24	140 - 240
1,6	20 - 26	160 - 260
2,0	22 - 27	220 - 280
2,4	24 - 28	280 - 340
2,8	25 - 29	320 - 400

FORMS OF DELIVERY:

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

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