

## **CORODUR<sup>®</sup> 476**

### **CLASSIFICATION:**

DIN EN 14700    DIN 8555  
T Z Fe7        MF 5-50-PRT

### **GENERAL CHARACTERISTICS:**

CORODUR 476 is a high Cr- Ni- Mo- Co- V- W- alloyed flux cored wire. It was especially developed for the hardfacing of rolls for hot rolling. The weld deposit is corrosion and wear resistant. Furthermore it is resistant to impact loads and continuous rating through heat effect and high pressure.

The hardfacing should be done in 2 - 3 layers. The finished layer should be 5 mm. The interpass temperature should not exceed 450°C.

### **APPLICATION:**

steel mill rolls

### **TYPICAL ALL WELD METAL ANALYSIS ( % ):**

C	Si	Mn	Cr	Ni	Mo	Co	V	W
0,3	0,3	0,8	16,0	4,0	1,5	1,0	1,0	1,0

### **TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:**

Hardness 48 - 50 HRc

### **PARAMETER:**

Diameter	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