

CORODUR[®] 55 Mo

CLASSIFICATION:

DIN EN 14700 DIN 8555
T Z Fe14 MF 10-60-G

GENERAL CHARACTERISTICS:

CORODUR 55 Mo is a highly alloyed C-, Cr-, and Mo- flux-cored wire electrode. It is suitable for the hardfacing of parts that are exposed to high abrasive mineral wear. The weld deposit is also rust resistant. The overlaying thickness should not exceed 8mm which means a deposit of between 2-3 layers, however the best results achievable are with 2 layers only. The deposit should be subjected to as little impact stresses as possible. Through choosing the smaller diameter wires along with an ideal energy input (meaning Voltage and Current), a crack-free weld deposit is possible. In comparison to CORODUR 55, the weld deposit has a higher temperature resistance which is due to the addition of Mo.

APPLICATION:

Coal crusher cones, liners, crusher rolls, pumps, mixer parts and conveyer screws.

TYPICAL ALL WELD METAL ANALYSIS (%):

C	Si	Mn	Cr	Mo
5,0	1,7	0,4	27,0	1,2

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

Hardness: 57 – 60 HRC

PARAMETER:

Diameter	Voltage	Amps
1,2	18 - 24	140 - 240
1,6	20 - 26	160 - 260
2,0	22 - 26	220 - 280
2,4	26 - 30	260 - 340
2,8	28 - 30	320 - 400

FORMS OF DELIVERY:

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

OA = gasless, SA = Submerged Arc