

CORODUR[®] 580

CLASSIFICATION:

DIN EN 14700 DIN 8555
T Fe3 MF 6-50-PT

GENERAL CHARACTERISTICS:

This C-, Cr-, Mo-, W- alloyed flux cored wire is suitable for hardfacing areas that require a deposit that is durable and abrasive resistant with excellent thermal fatigue properties. Preheating when welding CORODUR 580 is dependant on the base material. With complex base materials, a buffer layer should be used such as CORODUR 200 K or 250 K.

APPLICATION:

Guiding rolls, scale-breaker rolls, blooming- and slabbing-mill rolls hot working tool steels.

TYPICAL ALL WELD METAL ANALYSIS (%):

C	Si	Mn	Cr	Mo	V	W
0,35	0,6	2,0	6,5	1,5	0,5	1,2

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

Deposited Hardness: 48 - 52 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