

CORODUR[®] 59 L

CLASSIFICATION:

DIN EN 14700 DIN 8555
T Fe14 MF 10-60-CGT

GENERAL CHARACTERISTICS:

CORODUR 59 L is a highly C- Cr- Mo alloyed flux- cored wire for applications in high mineral wear with a corrosion resistant matrix. It is suitable for hard facing of parts that are exposed to high abrasion and partly corrosion. The overlaying thickness should not exceed 8-10mm which means a deposit of 2-3 layers. The deposit should be subjected to little impact stress. A crack free welding is possible with preheating- and interpass- temperature of min. 450 °C and oven cooling.

APPLICATION:

Kneading machines, liners, pumps, mixer parts, conveyer screws, mixer paddles, oil screws

TYPICAL ALL WELD METAL ANALYSIS (%):

C	Si	Mn	Cr	Mo
3,8	1,2	0,6	33,0	0,5

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

Hardness: 56 - 56 HRC

PARAMETER:

Diameter	Voltage	Amps
1,6	20 - 27	160 - 280
2,0	22 - 28	240 - 300
2,4	24 - 29	280 - 340
2,8	26 - 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