

CORODUR[®] 59 XL

CLASSIFICATION:

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

GENERAL CHARACTERISTICS:

CORODUR 59 XL is a C- Cr- Ni- 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	Ni	Mo
3,0	1,3	0,6	32,0	3,0	0,5

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

Hardness: 53 - 56 HRC

PARAMETER:

Diameter	Voltage	Amps
1,2	20 - 26	160 - 260
1,6	22 - 27	160 - 300
2,0	22 - 28	240 - 320
2,4	26 - 29	260 - 340
2,8	27 - 30	320 - 400

FORMS OF DELIVERY:

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

G = gas shielded, SA = Submerged Arc