

CORODUR[®] 60

CLASSIFICATION:

DIN EN 14700 DIN 8555
T Fe15 MF 10-60-G

GENERAL CHARACTERISTICS:

High C- Cr- Nb- alloyed flux- cored wire electrode for high abrasive wear up to 550 °C. The weld deposit consists of chrome - and niobium – carbides which are embedded into the matrix. The deposit should be subjected to little impact stress. Weld metal is not machinable. Maximum deposit should be limited to three layers and a thickness of 10 mm. Before overlaying sensitive base materials and old previously hardfaced surfaces a buffering layer of CORODUR 200 K or 250 K is recommended.

APPLICATION:

Mixer paddles, grinding rollers and grinding paths, wear plates, band transfers, chutes, hoppers, cement and concrete pumps, excavator teeth, steel, coal, cement and mineral industry

TYPICAL ALL WELD METAL ANALYSIS (%):

C	Si	Mn	Cr	Nb
5,2	1,1	0,4	22,0	7,0

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

Hardness: 61 - 63 HRc

PARAMETER:

Diameter	Voltage	Amps
1,2	18 - 27	140 - 240
1,6	20 - 27	160 - 280
2,0	22 - 26	220 - 300
2,4	24 - 27	260 - 340
2,8	25 - 28	320 - 440
3,2	26 - 30	350 - 520

FORMS OF DELIVERY:

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

OA = gasless, SA = Submerged Arc