

CORODUR[®] 609

CLASSIFICATION:

DIN EN 14700 DIN 8555
T Z Fe6 MF 6-55-RP

GENERAL CHARACTERISTICS:

High Cr-alloyed flux-cored wire electrode for welding wear resistant layers with a ferritic - martensitic micro structure. The welding deposit is high resistant to impact stress and medium abrasion. The deposit is in spite of the high hardness crack free also in multiple layers and can be used up to 700°C. Hot hardness 45 HRc at 450°C.

APPLICATION:

Crusher wheels and hammers, rock processing, shredders, cutting- tools, and fluid-valves and protection welding on Mn - hadfield - steel.

TYPICAL ALL WELD METAL ANALYSIS (%):

C	Si	Mn	Cr	Ni
0,5	2,8	1,2	9,5	0,3

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

Hardness: 55 - 57 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