

CORODUR[®] 68

CLASSIFICATION:

DIN EN 14700 DIN 8555
T Fe16 MF 10-70-CGZ

GENERAL CHARACTERISTICS:

Very high C- Cr- B-alloyed flux-cored open arc wire electrode for extreme hard and non-corrosive hardfacing to very high mineral wear also at high temperatures up to 800 °C. The weld deposit has a ledeburitic structure, bearing many various hypereutectic carbides. The deposit should be subjected to little impact stress. The weld deposit is nearly free of slag and the weldability is excellent. Good results are already achieved by welding one layer. Before cladding sensitive base materials and overlaying old previously hardfaced surfaces a ductile buffering layer of CORODUR 200 K or 250 K is recommended. The hardness reduction at a temperature of 400°C is approximately 5% and at 650°C approximately 10 %

A maximum deposit thickness of 1-2 layers is recommended.

APPLICATION:

coke oven screens, pulverizer, hammers also for glowing coke and slag.

TYPICAL ALL WELD METAL ANALYSIS (%):

C	Si	Mn	Cr	B
5,0	0,8	0,4	38,0	2,0

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

Hardness: 66 - 68 HRc

PARAMETER:

Diameter	Voltage	Amps
1,6	20 - 26	160 - 260
2,0	22 - 26	240 - 280
2,4	24 - 27	280 - 340
2,8	25 - 28	320 - 400
3,2	28 - 30	340 - 420

FORMS OF DELIVERY:

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

OA = gasless