

DURMAT[®] BK-SPHERICAL

**Welding Rod DIN EN 14700: T Ni20
(DIN 8555: G21-UM-55-CG)**

General characteristics:

DURMAT BK is a nickel cored flexible rod coated with mainly spherical fused / cast tungsten carbide (SFTC) and Ni-Cr-B-Si-matrix with a matrix hardness of 45 HRC. The hard facing is highly resistant to acids, bases, lye, and other corrosive media and excessive wear conditions. The rod has a low melting range of between 950 - 1050°C (1,742-1,922°F) and feature a self fluxing characteristic producing a smooth, clean welded surface.

Application:

Hard facing on ferritic and austenitic steels (steel castings), over-laying mixer blades, screws and conveyors in chemical, dye and food industry. Specially recommended for stabilizer blade in the petroleum industry.

Physical characteristics:

Hardness: SFTC: approx. ~3000 HV0.1
NiCrBSi-Matrix: approx. 420 – 450 HV0.1

Sales units:

Type	Ø mm	Ø inch	grain size mm	US mesh size
4005	4.0	5/32	0.25 - 0.84	20 – 60
5005	5.0	3/16	0.25 - 0.84	20 – 60
6005	6.0	1/ 4	0.25 - 0.84	20 – 60
8005	8.0	5/16	0.25 - 0.84	20 - 60

Welding recommendation:

The surface to be hard faced should be clean and free of rust, scale, grease or other contamination preferably by grinding or grit blasting. Deposits should be made by using a gas flame with neutral to slight acetylene balance.