

# DURMAT<sup>®</sup> NIFD-PLUS

**Flux-Cored Wire DIN EN 14700: T Ni20  
(DIN 8555: MF21-55-CGZ)**

## General characteristics:

DURMAT NIFD-PLUS is a cored metal wire filled with Ni-Cr-B-Si and spherical fused tungsten carbide (SFTC). DURMAT NIFD-PLUS was developed to protect surfaces where extreme abrasive wear in combination with corrosion are expected.

## Application:

Repairing and hard facing ferritic and austenitic steel tools and machine parts (steel castings) in the chemical industry and food industry. Stabilizers in the petroleum industry, mixer blades, conveyors and screws in the chemical and dye industry as well in the food processing industry.

## Physical characteristics:

Hardness: SFTC: > 3.000 HV<sub>0.1</sub>  
Matrix: approx. 450 – 480 HV<sub>0.1</sub>

## Welding recommendation:

Ø mm	Ø inch	Coil size DIN EN 759	Amps	Voltage
2.4	3/32	B 435 cages ca. 25 kg	200 - 230 A	21 - 23 V
2.8	7/64	B 435 cages ca. 25 kg	220 - 260 A	21 - 23 V
3.2	1/8	B 435 cages ca. 25 kg	240 - 280 A	23 - 25 V

The area to be hard faced should be free of rust, scale, oil and other contamination. Be sure that the base material is not overheated and choose amps and volts as low as possible to avoid decomposition the SFTC.

## Patents:

Germany: No. 40 08 091.9-41  
United Kingdom: No. 2.232.108  
USA: No. 5.004.886