

CORODUR[®] 4028

CLASSIFICATION:

DIN EN 14700

T Z Fe8

AWS-No. 420

GENERAL CHARACTERISTICS:

The tough and corrosion resistant overlay is well suited for parts that encounter wear from sea water plant and power plant operation. This acid corrosion resistance wire has a 14 % Cr content which forms the wearing analysis with a Carbon content of 0,3%. The weld parameters should be chosen with a low heat input as possible.

APPLICATION:

Bridge bearings, sealing surfaces, corrosion slide ring sealing, roller bearings, centrifuges, valves

TYPICAL ALL WELD METAL ANALYSIS (%):

C	Mn	Cr	Ni
0,3	0,8	14,0	0,4

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

Hardness: 46 – 48 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