

## **CORODUR<sup>®</sup> 813**

### **CLASSIFICATION:**

DIN EN 14700

T Fe8

### **GENERAL CHARACTERISTICS:**

CORODUR 813 is a flux cored wire, which produces a heat and thermal shock resistant deposit. The wire is designed for maintenance of hot working tools and to increase their service life. The number of layers can be done as necessary. The interpass temperature should be maximum 250°C. The alloyed weld deposit has excellent properties of resistance to impact. CORODUR 813 is still well machinable.

### **TYPICAL ALL WELD METAL ANALYSIS ( % ):**

C	Si	Mn	Cr	Ni	Mo	Ti
0,12	0,6	0,6	10,0	1,7	3,0	0,2

### **TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:**

Hardness: 41 - 47 HRc

Tensile strength: 1300 - 1500 N/mm<sup>2</sup>

### **PARAMETER:**

Diameter	Voltage	Amps
1,6	22 - 26	180 - 240
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

G = gas shielded