

CORODUR[®] 864

CLASSIFICATION:

DIN EN 14700

T Fe8

GENERAL CHARACTERISTICS:

CORODUR 864 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. The weld deposit is still well machinable.

TYPICAL ALL WELD METAL ANALYSIS (%):

C	Si	Mn	Cr	Mo	V	W	Ti
0,25	0,7	0,6	5,0	1,5	0,4	1,4	0,2

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

Hardness: 44 - 48,5 HRC

Tensile strength: 1400 - 1600 N/mm²

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