

CORODUR[®] 868

CLASSIFICATION:

DIN EN 14700

T Fe8

GENERAL CHARACTERISTICS:

CORODUR 868 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 with excellent properties of resistance to impact. CORODUR 868 is only machinable by flat engraving.

TYPICAL ALL WELD METAL ANALYSIS (%):

C	Si	Mn	Cr	Mo	V	W	Ti
0,40	0,8	0,6	6,0	3,0	0,7	3,0	0,2

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

Hardness: 52 - 55,5 HRC

Tensile strength: 1800 - 2000 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