CORODUR Das Original FÜLLDRAHT GMBH

CORODUR® 310

CLASSIFICATION:

DIN EN 14700	DIN 8555
T Fe7	MF 5-45-PRT

GENERAL CHARACTERISTICS:

CORODUR 310 is a Cr- Ni- Mo- alloyed tubular wire. The deposit is corrosion resistant and good to impact loads and has an excellent resistance to thermal fatigue. The number of layers can be done as necessary but 10 mm. A heat treatment of the high Cr-alloyed martensitic deposit in order to get a defined hardness is possible. The interpass temperature should be max. 450°C. The deposit is tough and can be worked with cutting tools.

APPLICATION:

Continuous casting rolls : new cladding and rewelding of all types of hot rolling mills and caster

TYPICAL ALL WELD METAL ANALYSIS (%):

C	Si	Mn	Cr	Ni	Mo	Nb	V
0,14	1,0	1,0	13,0	3,5	1,2	0,2	0,1

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

Hardness: 43 - 45 HRc

Hardness after heat treatment:

480°C	510°C	540°C	570°C	600°C
440-460 HB	400-440 HB	360-400 HB	300-360 HB	260-300HB

PARAMETER:

Diameter	Voltage	Amps
1,2	18 - 24	140 - 240
1,6	20 - 27	160 - 270
2,0	25 - 28	220 - 280
2,4	26 - 30	260 - 340
2,8	28 - 30	320 - 400
3,2	28 - 31	360 - 450
4,0	28 - 32	400 - 580

FORMS OF DELIVERY:

Coil "BS 300" = 15 kg | Coil "BS 450" = 25 kg | Drums = 300 kg

OA = gasless, G = gas shielded, SA = Submerged Arc

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