

CORODUR[®] 55

CLASSIFICATION:

DIN EN 14700 DIN 8555
T Z Fe14 MF 10-60-GR

GENERAL CHARACTERISTICS:

CORODUR 55 is a tubular wire which deposits a high C- and Cr- alloyed stainless weld metal with excellent resistance to abrasion and medium impact. It can be used whenever high abrasion is expected. Best results are achieved by welding in two layers. A maximum deposit thickness of 8 mm is recommended. Before cladding sensitive base materials and overlaying on old previously hard faced surfaces a buffering layer of CORODUR 200 K or CORODUR 250 K is recommended.

APPLICATION:

Pumps, mixer parts, stirring paddles, concrete pumps, conveyer screws, coke oven carriages

TYPICAL ALL WELD METAL ANALYSIS (%):

C	Si	Mn	Cr
4,8	1,2	0,6	29,0

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

Hardness: 55 –59 HRc

PARAMETER:

Diameter	Voltage	Amps
1,2	20 - 25	140 - 260
1,6	22 - 27	180 - 300
2,0	24 - 28	220 - 350
2,4	26 - 30	240 - 360
2,8	27 - 30	320 - 420

FORMS OF DELIVERY:

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

OA = gasless, SA = Submerged Arc