

## **CORODUR<sup>®</sup> 600**

### **CLASSIFICATION:**

DIN EN 14700    DIN 8555  
T Fe3            MF 6-60-RP

### **GENERAL CHARACTERISTICS:**

C- Mn- Cr- Mo- V- alloyed flux-cored wire electrodes for abrasion and impact resistant hardfacing. The deposit is crack-free, hard, tough and heat resistant up to 500°C. An increase of hardness by annealing is possible. For base materials that are difficult to weld, a buffer layer of 200 K or 250 K is recommended. Preheating is recommended. Applications are crusher wheels, dredger parts, pan grinders, and as the final layer for hardfacing manganese steel.

### **APPLICATION:**

dredging parts, gravel pumps, blowbars, screws, crusher hammers, drive tumblers

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

C	Si	Mn	Cr	Mo	V
0,5	1,0	2,2	6,5	0,6	0,2

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

Hardness: 55 - 57 HRc

### **PARAMETER:**

Diameter	Voltage	Amps
1,2	20 - 24	150 - 200
1,6	22 - 26	180 - 240
2,0	25 - 27	220 - 260
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

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