

CORODUR[®] 69

CLASSIFICATION:

DIN EN 14700 DIN 8555
T Fe16 MF 10-65-GRZ

GENERAL CHARACTERISTICS:

CORODUR 69 is a tubular wire for extreme abrasive wear, even at high temperatures up to 650°C. The deposit has a very fine ledeburitic structure, bearing a lot of different very hard carbides . CORODUR 69 is used, wherever abrasive wear is extremely high. It is also wear resistant at high temperatures up to 650 °C. Due to the high hardness pre heating of the base metal is recommended. The deposit should be subjected to little impact stress. The deposit is nearly free of slag; the weldability is excellent. Good results are already achieved by welding one layer. A maximum deposit thickness of 6 to 8 mm (2 layers) is recommended. The resulting deposits cannot be heat-treated, machined or forged.

Before overlaying on old previously hard-faced surfaces a buffering layer of CORODUR 200 K or 250 K is recommended.

APPLICATION:

Concrete-industry, mixer parts, extruder, scrapers, sintering grates, mining

TYPICAL ALL WELD METAL ANALYSIS (%):

C	Si	Mn	Cr	Nb	B
5,2	0,8	0,4	32,5	5,8	1,8

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

Hardness: 64 – 67 HRc

PARAMETER:

Diameter	Voltage	Amps
1,6	20 - 26	160 - 260
2,0	22 - 26	240 - 280
2,4	24 - 27	280 - 340
2,8	25 - 28	320 - 400

FORMS OF DELIVERY:

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

OA = gasless