

CORODUR[®] 78

CLASSIFICATION:

DIN EN 14700 DIN 8555
T Fe 16 MF 10-70-GZ

GENERAL CHARACTERISTICS:

C- Cr- Nb- V- B -alloyed flux-cored wire electrode for extreme mineral wear. Due to the high V-content fine hard particles and a high hardness of the matrix is existent. The weld deposit has a high scratch hardness. The deposit should be subjected to little impact stress. The deposit is nearly free of slag; the weldability is excellent. The wear resistance is up to 650°C nearly constant. The hardness reduction at a temperature of 400°C is approximately 8% and at 650°C approximately 20 %. Best results are achieved by welding in 2 layers. Before overlaying on sensitive base materials or old previously hard-faced surfaces a buffering layer of CORODUR 200 K or preheating is recommended.

APPLICATION:

Mining and clinker industry, gravel industry, sand and concrete pumps, mixer parts, conveyor screws, lignite mining machines, sinter plants, chains

TYPICAL ALL WELD METAL ANALYSIS (%):

C	Si	Mn	Cr	Nb	V	B
5,0	1,3	0,5	16,0	6,5	6,5	1,0

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

Hardness: 64 – 68 HRc

PARAMETER:

Diameter	Voltage	Amps
1,2	18 - 24	140 - 220
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