

CORODUR[®] WZ 50

CLASSIFICATION:

DIN EN 14700 DIN 8555
T Fe3 MF 3-50-ST
Alloy-No. 1.2567

GENERAL CHARACTERISTICS:

This C- Cr-V- W- alloyed flux-cored wire electrode is suitable for repair and build- up applications on hot working steels of similar or lower alloyed hot working tools. The weld deposit is machinable, heat treatment is possible and has a retention of hardness up to 550°C.

APPLICATION:

Forging dies, hot shear blades, mandrels

TYPICAL ALL WELD METAL ANALYSIS (%):

C	Si	Mn	Cr	V	W
0,3	0,6	0,4	3,0	0,6	4,5

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

Hardness after welding: 48 – 52 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