

CORODUR[®] WZ 57

CLASSIFICATION:

DIN EN 14700 DIN 8555
T Z Fe4 MF 4-60-STW

GENERAL CHARACTERISTICS:

CORODUR WZ 57 is a flux cored wire which deposits an air hardening and wear resistant alloy and can be applied to reclaim hot-forging dies and to overlay the edges and flat areas of low alloyed high density steel tools. CORODUR WZ 57 is typically applied on: slab shears, hot-forging dies, drawing dies, containers, crushing equipment and depressions created by forging, pressure and impact stress. Before heat treatment the weld deposit is machinable.

APPLICATION:

Heat treatment retentivity, hot hardening

TYPICAL ALL WELD METAL ANALYSIS (%):

C	Si	Mn	Cr	Mo	Co	V	W
0,35	0,8	0,8	13,0	2,2	10,0	0,25	5,5

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

Hardness: 50 - 53 HRc
Or hot hardening: 55 - 59 HRc
(1h of 500 - 550°C)

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