

CORODUR[®] SER

CLASSIFICATION:

DIN EN 14700 DIN 8555
T Z Fe10 Special alloy

GENERAL CHARACTERISTICS:

CORODUR SER is an Iron-based flux cored wire, with the deposit located in the low leveled brittle phase. The deposit is also suitable for heat-hardening in a temperature level of 520°C - 540°C up to a hardness of 48 HRC. This gives the deposit similar wear resistant properties as the Cobalt-based special alloys in that they have excellent abrasive wear at high temperatures. This wire is ideal as a substitutional alloy when Cobalt-based alloys are not useable for example in the nuclear industry or when surface cracking is to be limited.

Recommended gas: Argon or Argon S1

APPLICATION:

Pressure and gliding surface hardfacing, valves , slip-ways (shipyards)

TYPICAL ALL WELD METAL ANALYSIS (%):

C	Si	Mn	Cr	Ni	Mo	Nb	Fe
<0,1	4,5	4,8	18,0	8,5	5,5	1,0	bal.

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

Hardness: 46 – 50 HRc

Hardness oven cooling 2h: 56 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

G = gas shielded, SA = Submerged Arc