DIN EN 14700 **T Fe 15-60-GC**

CORODUR® 56

The high content of hard hypereutectic phases M7C3 makes the alloy suitable for high abrasive wear using CORODUR® 56, a flux cored wire electrode, which is highly C- and Cr- alloyed. The weld deposit has a high corrosion resistance. Best results are achieved by welding in 2-3 layers with max. 10 mm thickness. The deposit should be subjected to little impact stress. Before cladding sensitive base materials and overlaying old, previously hard-faced surfaces, a ductile buffering layer of CORODUR® 200 K or 250 K is recommended.

ABRASION RESISTANT APPLICATIONS

Wear plates, ventilators, coke oven carriage, NI- Hard IV.

TYPICAL ALL WELD METAL ANALYSIS (%) — Base = Fe

C	Si	Mn	Cr	B
5,4	1,0	0,4	30,0	+

Hardness HRc	58-62

PARAMETER

Diameter	Voltage	Amps
1,2	18-24	160-240
1,6	22-26	180-280
2,0	22-26	220-320
2,4	26-30	260-340
2,8	28-30	320-420

FORMS OF DELIVERY

Unit	Weight
Coil BS 300	15 kg
Coil B 450	25 kg
Drums	300 kg

OA = Open Arc