

CORODUR® 250 K

DIN EN 14700 T Fe 9-250-KNP

An excellent choice for a highly Mn-Cr- alloyed flux cored wire is the CORODUR® 250 K. The fully austenitic weld material has high plasticity and acts as a plastic buffer. Deposits have a work hardening up to 500 HB, are stainless and non-magnetic. CORODUR® 250 K is suitable for welding buffer layers before welding over old hardfacing, because it deposits a ductile weld metal. The deposit resists high shrinkage stresses and impact loadings.



Repair of: manganese steel buckets and shovels, high tensile tools, mill-shafts, clutches, crane wheels, earthmoving undercarriage parts, gear wheels, crusher, rails and crossovers, buffer layers.

TYPICAL ALL WELD METAL ANALYSIS (%)

Base = Fe

C	Si	Mn	Cr	Ni	Mo	V
0,5	0,4	16,0	14,0	0,8	0,5	0,2

Hardness HB

220-250

500
Work hardened

PARAMETER

FORMS OF DELIVERY

Diameter	Voltage	Amps	Unit	Weight
1,2	18 - 24	140 - 240	Coil BS 300	15 kg
1,6	20 - 26	160 - 260	Coil B 450	25 kg
2,0	22 - 27	220 - 280	Drums	300 kg
2,4	24 - 28	280 - 340		
2,8	25 - 29	320 - 400		

G = Gas shielded, OA = Open Arc, SA = Submerged Arc