

# DURMAT<sup>®</sup> FD 240 K

## Classification:

DIN EN 14700  
T Fe9 (MF 7-200-KN)

AWS A 5.13  
E Fe Mn – A

## General Characteristics:

DURMAT<sup>®</sup> FD 240 K is a flux core wire, which enables the deposition of a non magnetic austenitic 14 % Mn coating, which is tough, crack free and can be work hardened up to 450 HB. DURMAT<sup>®</sup> FD 240 K is designed for repairing worn parts of similar base materials as well as for hard facing carbon steels parts to severe impact loads. In that case an austenitic buffer layer should be applied. The alloy should be welded with a minimum heat input in one or more layers.

## Application:

Hardfacing of crushers, swing hammers, railway crossings, dredge buckets, etc.

## Chemical composition (in wt-%):

C	Mn	Cr	Ni	Fe
1	14	4	0.6	Balance

## Physical characteristics:

Hardness: 200-230 HB when deposited  
400-450 HB when hardened

## Sales units:

Coil "S" 15 kg  
Coil "B" 25 kg  
Drum 250 kg

## Welding recommendation:

Ø mm	Ø inch	Amps	Voltage
1.6	1/16	180 - 220	20 - 26
2.0	5/64	220 – 250	22 – 26
2.4	3/32	260 – 300	24 – 27
2.8	7/64	300 – 340	27 - 28