DURMAT® FD 250 K

Classification:

DIN EN 14700	DIN 8555
T Fe9-2500-KNP	MF 7-250-KNP

General Characteristics:

DURMAT® FD 250 K is a flux core wire of the Mn-Cr-type. The complete austenitic weld material shows high plasticity and can be applied as a buffer layer. Deposits can be work hardened up to 500 HB, are stainless and not magnetic. The deposits resist high shrinkage and impact stresses.

Application:

Repair of manganese steel buckets and shovels, high tensile tools and dies, clutches, crane wheels, earthmoving undercarriage parts, gear wheels, etc.

Typical chemical composition (in wt-%):

C	Si	Mn	Cr	Ni	Mo	V	Fe
0.5	0.4	16	14	0.8	0.5	0.2	Balance

Physical characteristics:

Hardness	200 - 250 HB when deposited 450 - 500 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