



DURMAT® FD 51

Flux-Cored Wire for Hardfacing

DIN EN 14700
DIN 8555

T Fe 15-60-G
MF 10-60-G

General characteristics:

DURMAT® FD 51 OA is a Flux-Cored Wire which deposits a martensitic matrix with a high content of Cr-Carbides M_7C_3 with excellent resistance to abrasion and medium impact up to 450°C (842°F). It can be applied whenever high abrasion is expected. Best results are achieved by welding in two layers. The deposit cannot be machined or forged. Before overlaying old previously hardfaced surfaces, a buffering layer of DURMAT® FD 200 K or DURMAT® FD 250 K is recommended.

Application:

Pumps, mixer parts, conveyor screws, shovel-bucket, scrapers, blades, fan-blades.

Typical chemical composition (in wt.-%):

C	Si	Mn	Cr	B	Fe
4.5	1.2	1.0	22	+	Bal.

Typical physical characteristics:

Hardness: 58-59 HRC

Sales units:

Product types: OA
Spool BS 300 (DIN EN ISO 544): 15 kg
Spool B 450 (DIN EN ISO 544): 25 kg
Drum: 150/250 kg

Welding recommendation:

Ø [mm]	Ø [inch]	Amperage [A]	Voltage [V]
1.2	.045	150-240	18-26
1.6	1/16	180-340	19-27
2.0	5/64	220-360	22-28
2.4	3/32	240-380	24-28
2.8	7/64	260-400	25-28
3.2	1/8	280-420	25-28

DURUM Verschleißschutz GmbH
Carl-Friedrich-Benz-Str. 7, 47877 Willich, Deutschland
Tel.: +49 (0) 2154 48 37 0, Fax: +49 (0) 2154 48 37 78
www.durmat.com; info@durum.de



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