

DURMAT[®] FD 60

Classification:

DIN EN 14700
T Fe15 (MF 10-60-G)

General Characteristics:

DURMAT[®] FD 60 is a flux core wire for hardfacing especially for extreme abrasive wear. The deposit has a ledeburitic structure with different very hard types of carbide.

DURMAT[®] FD 60 is used where ever abrasive wear is extremely high because it offers an excellent resistance against abrasion. The deposit is free of slag, weldability is excellent. Best results are achieved by welding in two layers. A maximum deposit thickness of 8 mm is recommended. The resulting deposits cannot be heat treated, machined or forged. Before overlaying previously hardfaced surfaces a buffer layer of DURMAT[®] FD 200 K or DURMAT[®] FD 250 K is recommended.

Application:

Hardfacing on parts for coal mining equipment, cement and mineral industries.

Chemical composition (in wt-%):

C	Si	Mn	Cr	Nb	Fe
5.2	1.1	0.4	22	7	Balance

Physical characteristics:

Hardness: 61 - 63 HRC

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