

DURMAT[®] FD 600

Classification:

DIN EN 14700
T Fe8 (MF 6-55-PT)

General Characteristics:

DURMAT[®] FD 600 is a flux core wire which enables a CrMoV alloyed deposit for semi automatic and automatic surfacing. The weld metal enables hardness up to 58 HRC even with relatively slow cooling rates. Crack resistance is good in case of adequate preheat and interpass temperature together with slow cooling after welding. Resistance to tempering is good.

Application:

Parts subjected to abrasion, impact and compressive loads, sand pumps, dredge pump parts, dredge ladder rolls, etc.

Chemical composition (in wt-%):

C	Si	Mn	Cr	Mo	V	Fe
0.5	1	3	6.5	0.8	0.4	Balance

Physical characteristics:

Hardness: 55 - 58 HRC (650 HV)

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