

DURMAT[®] FD 61

Classification:

DIN EN 14700
T Fe15 (MF 10-65-G)

General characteristics:

DURMAT FD 61 is a flux core wire for hardfacing and is resistant to extreme abrasive wear. The deposit has a ledeburitic structure with a high content of different hard phases.

DURMAT[®] FD 61 is used at extreme abrasive wear due to its 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 deposit 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	Others	Fe
5.2	1.3	0.4	22	7	3	Balance

Physical characteristics:

Hardness 62 - 65 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