

DURMAT[®] FD 720

Classification:

DIN EN 14700
Special Alloy

DIN 8555
Special Alloy

General characteristics:

DURMAT[®] FD 720 is a low alloyed flux core wire. The weld deposit is suitable for parts subject to impact, metal to metal friction and severe fine particle abrasion/erosion load. It is a complete martensitic deposit which is rich in iron-borides and iron-carbides. The working temperature should not exceed 200°C to keep wear minimal.

Application:

Dredges, concrete pumps, driving screws, fine particle (sand) wearing parts.

Typical chemical composition (in wt-%):

C	Si	Mn	Ni	B	Fe
0.7	1	2	2	4.5	Balance

Physical characteristics:

Hardness: 65 - 68 HRC

Sales units:

Coil "S" 15 kg
Coil "B" 25 kg
Drum 250 kg

Welding recommendation:

Ø mm	Ampere	Volt
1.2	120 - 220	18 - 25
1.6	160 - 260	20 - 26
2.0	240 - 280	22 - 26
2.4	280 - 340	24 - 27
2.8	320 - 400	27 - 29