



DURMAT[®] FD 723

Flux-Cored Wire for Hardfacing

DIN EN 14700
DIN 8555

T Fe13-65-G
Special alloy

General characteristics:

DURMAT[®] FD 723 is a C-Cr-B alloyed flux-cored wire with a martensite-carbide structure with additional Iron- and Chrome borides. Welds have a high hardness even in the first layer and also on stainless steel. Maximum operating temperature is 450 °C (840 °F). A maximum of 2 layers is recommended. DURMAT[®] FD 723 can be welded by gas metal arc welding (MIG/GMAW) with shielding gas M21 according to DIN EN ISO 14175 (18% CO₂) or open arc (OA) without shielding gas.

Application:

Machine or structural components exposed to severe abrasive and erosive wear without high impact loads, sand excavation, feeding screws, industrial fans, pumps, agricultural parts, ceramic industry, cyclones and mixers.

Typical chemical composition (in wt.-%):

C	Si	Mn	Cr	B	Ni	Fe
1.6	1.4	0.40	7.5	4.4	+	Bal.

Typical physical characteristics:

Hardness: on mild steel S235JR / S355J2 64-68 HRC
on stainless steel 1.4303 / 1.4828 63-66 HRC

Sales units:

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

Welding recommendation:

Shielding gas (DIN EN ISO 14175): M21, (M13)

Ø [mm]	Ø [inch]	Amperage [A]	Voltage [V]
1.2	.045	140-240	22-25
1.6	1/16	180-280	22-26
2.0	5/64	220-300	22-26
2.4	3/32	260-340	23-26
2.8	7/64	320-400	24-27

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