



# DUROLOY® 521

Flux-Cored Wire for Hardfacing

DIN EN 14700  
DIN 8555

T Ni4-250-CKPTZ  
MF 23-GZ-250-CKTZ

## General characteristics:

DUROLOY® 521 deposits a CrCoMoTiAlW-alloyed nickel based weld metal. It is designed for gas shielded welding with pure Argon. The weld metal is a precipitation hardenable alloy with an exceptional combination of high temperature mechanical property, forgeability and corrosion resistance. To obtain a crack free deposit, the work piece should be pre-heated to a temperature of about 350 C (662°F). Slow cooling after welding is advised.

## Application:

Critical high temperature applications like hot forging dies or hot shear blades.

## Typical chemical composition (in wt.-%):

C	Si	Mn	Cr	Mo	W	Co	Ti	Al	Fe	Ni
0.06	0.80	0.50	20	6.0	0.80	11	3.0	2.0	3.0	Bal.

## Typical physical characteristics:

Hardness: as-welded 250-320 HB  
work hardened 40-45 HRC

## Sales units:

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

## Welding recommendation:

Shielding gas (DIN EN ISO 14175): I1

Ø [mm]	Ø [inch]	Amperage [A]	Voltage [V]
1.2	.045	120-200	20-25
1.6	1/16	140-240	21-26
2.0	5/64	160-300	23-27
2.4	3/32	180-340	24-28

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