DUROLOY CO

Classification:

DIN EN 14700	DIN 8555	SME SFA – 5.11	Werkstoffnummer
T Ni2-250-CKNPT	MF 23-250-CKNPTZ	E – NiMoCr – 1	2.4887

General Characteristics:

DUROLOY CO can be applied by shielded arc welding, resulting in a heat and wear resistant hard facing. This deposit is resistant to oxidation, reduction and other corrosive media. When first applied to hot forging dies, the overlay is very cohesive. Exposed to impact and pressure load and even at elevated temperature, the resulting hard facing deposit increases in hardness up to 400 HB without deforming. For thick layers of DUROLOY CO, a buffer layer based on the alloys 1.4337 or 1.4370 should be applied. Depending on the base metal, the area to be hard faced should be preheated to 300 $^{\circ}$ C – 400 $^{\circ}$ C.

Application:

For hardfacing on forging dies and other hot working tools.

Typical chemical composition (in wt-%):

С	Мо	Cr	Со	V	W	Fe	Ni
0.08	16	16	2.5	0.35	4.5	< 5	Balance
Physical characteristics:							
Hardness:		260 – 280 HB after work hardening: 420 HB					
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	160 - 220	18 – 24
2.0	5/64	220 - 260	20 – 25
2.4	3/32	260 - 340	23 – 26
2.8	7/64	300 - 400	25 - 28