

# DURMAT® FD 495

## Classification:

DIN EN 14700  
T Fe8-50-CKTZW

DIN 8555  
MF 3-GF-50-CKTZW

## General Characteristics:

The stainless weld deposit on Fe, Cr, Co, Mo-basis has a high wear resistance even at elevated temperatures, a high tensile strength and a high resistance against sliding wear of metallic objects. Deposits can be work hardened up to 53 HRC and show good thermal shock resistant.

## Application:

Hardfacing of forging presses, hot piercing dies, stretching rolls, pinch rolls, hot strip mill table rolls and back-up rolls.

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

C	Si	Mn	Cr	Mo	Co	Fe
0.1	0.7	0.4	15	3.2	14	Balance

## Physical characteristics:

Hardness:

Untreated: 48 - 50 HRC  
work hardened: 53 HRC  
Drawn for 2 h at  
480°C: 51 HRC  
600°C: 53 HRC  
700°C: 48 HRC  
760°C: 40 HRC

## Sales units:

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

## Welding recommendation:

Ø mm	Amps	Voltage
1.6	160 - 260	20 – 26
2.0	220 - 280	22 – 26
2.4	280 - 340	24 – 27
2.8	320 - 400	25 - 28