

DURMAT[®] FD 59 L

Classification:

DIN EN 14700
T Fe14-60-CGT

DIN 8555
MF 10-60-CGT

General Characteristics:

DURMAT[®] FD 59 L is a flux core wire, which deposits a high CrC-alloy. It can be used whenever high abrasion accompanied by corrosion is expected. It is not recommended for impact wear conditions. DURMAT[®] FD 59 L is deposited crack free by controlling the operational conditions. It is recommended that the work piece be preheated up to 450°C and this temperature maintained throughout the complete welding process. After Welding, the component should be cooled slowly preferably in the furnace. Best results are achieved by welding in two layers. A maximum deposit thickness of 8 mm is recommended. The resulting deposits cannot be heat treated, machined or forged. Before overlaying previously hard faced surfaces a buffer layer of DURMAT[®] FD 200 K or DURMAT[®] FD 250 K is recommended.

Application:

Hardfacing on pumps, mixers, impellers and screws, particularly when these parts are subject to wear by abrasion and corrosion.

Typical chemical composition (in wt-%):

C	Si	Mn	Cr	Mo	Fe
3.8	1.2	0.6	33	0.5	Balance

Typical physical characteristics:

Hardness: 56 - 59 HRC

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	180 - 220	20 - 26
2.0	5/64	220 - 250	22 - 26
2.4	3/32	260 - 300	24 - 27
2.8	7/64	300 - 340	27 - 28