

DURMAT[®] FD 601

Classification:

DIN EN 14700
T Fe6-60-PT

DIN 8555
MF 6-60-PT

General Characteristics:

DURMAT[®] FD 601 is a flux core wire which enables a CrMoWV alloyed deposit for semi automatic and automatic surfacing. The weld metal enables hardness up to 60 HRC even with relatively slow cooling rates. Crack resistance is good in case of adequate preheat and interpass temperature together with slow cooling after welding. Resistance to tempering is good.

Application:

Parts subjected to abrasion, impact and compressive loads, sand pumps, dredge pump parts, dredge ladder rolls, tool - joints , etc.

Typical chemical composition (in wt-%):

C	Si	Mn	Cr	Mo	V	W	Fe
0.5	1	3	6.5	1.5	1.5	1	Balance

Physical characteristics:

Hardness: 55 - 58 HRC

Sales units:

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

Welding recommendation:

Ø mm	Ø inch	Amps	Voltage
1.2	0.045	120 - 220	18 - 25
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