

DURMAT[®] FD 609

Classification:

DIN EN 14700
T Fe8-55-RP

DIN 8555
MF 6-55-RP

General Characteristics:

High Cr-alloyed flux core wire for wear resistant hardfacing with a ferritic – martensitic micro structure. The welding deposit is high resistant against impact stress and medium abrasion. The deposit is despite the high hardness crack free also in multiple layers and can be used up to 700° C.

Application:

Crusher wheels and hammers, rock processing shredders, cutting-tools, and fluid valves and protection welding on Mn-Hadfield-steel.

Typical chemical composition (in wt-%):

C	Si	Mn	Cr	Ni	Fe
0.5	2.8	1.2	9.5	0.3	Balance

Typical physical characteristics:

Hardness: 55 - 57 HRC
450° C: 45 HRC

Sales units:

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

Welding recommendation:

Ø mm	Ampere	Volt
1.2	140 - 240	18 – 24
1.6	160 - 260	20 – 26
2.0	240 - 280	22 – 26
2.4	280 - 340	24 – 27
2.8	320 - 400	25 - 28