

DURMAT[®] FD 62

Classification:

DIN EN 14700
T Fe15 (MF 10-60-G)

General characteristics:

DURMAT[®] FD 62 is a high C-Cr-alloyed flux core wire. The alloy is especially made for overlaying parts which are exposed to very extreme abrasive mineral wear related to the high amount of hard phases like hypereutectic M₇C₃-carbides. For best results avoid to apply the hardfaced area to pounding or impact load. DURMAT FD 62 should be applied in 2 layers with a maximum height of 10 mm. Before overlaying a previously hardfaced surface a buffer layer of DURMAT[®] 200 K or DURMAT[®] FD 250 K is recommended.

Application:

Wear plates, spiked rollers, cement and concrete pumps, dredging teeth, slag breakers, coke oven slides and Ni-Hard IV.

Chemical composition (in wt-%):

C	Si	Mn	Cr	Nb	Fe
5.4	1.2	1.6	29	3	Balance

Physical characteristics:

Hardness: 60 - 63 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