DURMAT[®] FD 65

Classification:

DIN EN 14700 T Fe16 (MF 10-65-GZ)

General Characteristics:

DURMAT[®] FD 65 is a flux core wire for hardfacing application especially with extreme abrasive wear even at elevated temperatures. The deposit has a ledeburitic structure with many different very hard types of carbides. DURMAT[®] FD 65 is used where extreme abrasive wear is expected even at elevated temperatures up to 600°C. The deposit is free of slag, weldability is excellent. 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 hardfaced surfaces a buffer layer of DURMAT[®] FD 200 K or DURMAT[®] FD 250 K is recommended.

Application:

Blast furnace bells, coke oven screens and doors, sinter wheel breakers, smelter loading chutes, etc.

Chemical composition (in wt-%):

С	Si	Mn	Cr	Мо	Nb	V	W	Fe
5.2	1	0.4	21	7	7	1	2	Balance
Physical characteristics:Hardness:20 °C:63 - 65 HRC								
				400 °C: 600 °C: 800 °C:	61 H 57 H 52 H	IRC		
Sales unit	s:							
Coil "S"				15 kg				
Coil "B"				25 kg				
Drum				250 kg				
Welding r	ecommen	dation:						
Ø	mm		Ø inch		Amps		Volta	ge

Ømm	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

Please observe all appropriate safety regulations in force. The technical informations given in this data sheet reflects the present state of knowledge. They do not form part of any sales contract as guaranteed properties of the delivered materials. Our delivery and sales conditions apply to all contracts included. Rev. 9 - 02/2007