

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-%):

C	Si	Mn	Cr	Mo	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:	61 HRC
	600 °C:	57 HRC
	800 °C:	52 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