

DURMAT[®] FD 733

Classification:

DIN EN 14700
T Fe8

DIN 8555
MF 10-70 GT

General characteristics:

DURMAT[®] FD 733 is a flux core wire containing extremely hard chrome-carbides and niobium-carbides embedded in a FeBC matrix. The weld deposit is very fine-grained and extremely hard – also in the first layer 67 HRC can be achieved. It is suitable for hardfacing on parts requiring high abrasion resistance with at the same time minor impact resistance and wear resistance up to a working temperature of approx. 450 °C.

Application:

Worm conveyer screws, sand-preparing plants, dredgers, mixers, ceramic industry, fan baffles, pump casings, briquette plants etc.

Typical chemical composition (in wt-%):

C	Si	Mn	Cr	Nb	B	Fe
4	0.8	1.5	19	4	1.5	Balance

Physical characteristics:

Hardness: 66 - 68 HRC

Sales units:

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

Welding recommendation:

Ø mm:	Ampere:	Volt:
1.2	120 - 220	18 - 25
1.6	160 - 280	20 - 26
2.0	220 - 300	22 - 26
2.4	280 - 340	24 - 27
2.8	320 - 400	25 - 28