

# DURMAT® FD 739

## Classification:

DIN EN 14700  
T Fe16

## General characteristics:

DURMAT® FD 739 is an iron based flux cored wire containing complex carbide phases which are precipitated more fine than in common used hardfacings. These layers show a better resistance against abrasive and erosive load because of the finely divided hard particles which have a submicron grain size. This fine structure results of the advantage concerning the percentage contact area of the fine hard phases in comparison to common hard phase grain sizes.

## Application:

On parts with high abrasive and erosive load, which could be superposed by corrosive attack.

## Typical chemical composition (in wt-%):

C	Cr	Mo	Nb	W	B	Fe
1	22	3.5	3.7	5.6	4.6	Rest

## Typical physical characteristics:

Hardness: 67 - 70 HRC

## Sales units:

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

## Welding recommendation:

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