DURMAT® FD 78

Classification:

DIN EN 14700
T Fe16 (MF 10-70-GZ)

General characteristics:

C-, Cr-, V-, Nb-alloyed flux core wire against extreme mineral wear. The weld deposit has a high scratch hardness. Best results are achieved by welding 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:

Applications are sinter plants, lignite mining machines, gravel industry, chains, clinker industry, concrete pumps.

Chemical composition (in wt-%):

C	Si	Mn	Cr	Nb	V	B	Fe
5	1.3	0.5	16	6.5	6.5	1	Balance

Physical characteristics:

Hardness	64 - 68 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	160 - 260	20 - 26
2.0	5/64	220 - 280	22 - 27
2.4	3/32	260 - 340	24 - 28
2.8	7/64	300 - 400	25 - 29