

DURMAT FD 79

CLASSIFICATION:

DIN EN 14700
T Fe 16-70-GZ

GENERAL CHARACTERISTICS:

DURMAT FD 79 is a self-shielded flux-cored wire electrode, with a high amount of chrom-, vanadium and niobium carbides as well as extra hard metal borides. According to the high content of alloy components the hard facing resists mineral wear even at elevated temperatures. Wear resistance will be given up to and service temperature of approx. 650 °C. Best results will be achieved by welding in two layers. The hard facing should not be loaded with impact or shock stress. In-sensitive base materials or before overlaying previously hard faced surfaces a buffer layer of DURMAT® FD 250 K is recommended and or appropriate preheating is recommended. The hardness decreases at 400 ° C by 8% at 650 ° C by about 20%.

APPLICATION:

Sand- and concrete pumps, mixer parts, conveyer screws, Hardfacing on parts for coal mining equipment, cement and mineral industries.

TYPICAL ALL WELD METAL ANALYSIS (%):

C	Si	Cr	Nb	V	B
5,0	1,0	21,0	7,0	2,5	1,3

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

Hardness: 64 – 68 HRc

PARAMETER:

Diameter	Volt	Ampere
1,2	18 - 24	120 - 220
1,6	20 - 26	160 - 260
2,0	22 - 26	240 - 280
2,4	24 - 27	280 - 340
2,8	25 - 28	320 – 400

FORMS OF DELIVERY:

Coil "BS 300" = 15 kg | Coil "BS 450" = 25 kg | pay off pack = 250 kg