

DURMAT[®] FD WZ 55

Classification:

DIN EN 14700
T Fe3-55-STW

DIN 8555
MF 3-50-ST

Standard No.
1.2767

General characteristics:

DURMAT[®] FD WZ 55 is a cored wire which deposits an air hardening and wear resistant alloy and can be applied to reclaim hot-forging dies and to overlay the edges and flat areas of low alloyed high density steel tools.

Application:

Slab shears, hot-forging dies, hot shear blades drawing dies, containers, crushing equipment and depressions created by forging, pressure and impact stress.

Typical chemical composition (in wt-%):

C	Si	Mn	Cr	Nb	V	W	Fe
0.35	0.8	1.2	3	2	0.5	7	Balance

Physical characteristics:

Hardness: 53 - 56 HRC
after heat treatment:
56 - 58 HRC (2 h, 500 – 550°C, air)
240 HB (4-6 h, 800-850 °C,
cooling in furnace)

Sales units:

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

Welding recommendation:

Ø mm	Amps	Voltage
1.2	120 - 220	18 - 25
1.6	140 – 260	18 - 27
2.0	180 - 280	20 - 28
2.4	280 - 340	23 - 29
2.8	320 - 400	25 - 30