

DURMAT[®] FD WZ 59

Classification:

DIN EN 14700
T Fe4-55-ST

DIN 8555
MF 4-55-ST

General characteristics:

The wear and heat resistant deposit of this flux-cored wire electrode in high speed steel quality is suitable for repair and manufacture of hot and cold working tools, stamps and counter dies. etc. The weld deposit can be heat treated and has a retention of hardness up to 550 °C.

Application:

high speed steel tools, pinion-type cutters, chisels

Typical chemical composition (in wt-%):

C	Si	Mn	Cr	Mo	W	Fe
0.5	0.6	1.2	5	3.5	3.5	Balance

Typical physical characteristics:

Hardness: 57 - 59 HRC

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

Preheating: 150-300°C (low alloyed steels)
300-400°C (tool steels)