



DURMAT[®] FD 42 MIG

Flux-Cored Wire for Hardfacing

DIN EN 14700

T Fe14-45-CGT

General characteristics:

DURMAT[®] FD 42 MIG is a flux cored wire for hardfacing with resistance to wear and corrosion. The deposit is high Cr-, Ni-, Mo-, and C-alloyed and is used at any place where corrosive as well as abrasive wear is expected. Welds can be carried out crackfree. The alloy can be worked with metalloid cutting tools. DURMAT[®] FD 42 MIG is developed for gas shielded welding with M13-Argon (with 1-2% oxygen).

Application:

Vegetable oil extrusion presses, meat processing and food industry, chemical industry.

Typical chemical composition (in wt.-%):

C	Si	Mn	Cr	Ni	Mo	Fe
1.9	1.0	1.0	28	3.0	0.80	Bal.

Typical physical characteristics:

Hardness: 41-44 HRC

Sales units:

Product types: MIG
 Spool BS 300 (DIN EN ISO 544): 15 kg
 Spool B 450 (DIN EN ISO 544): 25 kg
 Drum: 150/250 kg

Welding recommendation:

Shielding gas (DIN EN ISO 14175): M13 (also M21, M23 possible)

Ø [mm]	Ø [inch]	Amperage [A]	Voltage [V]
1.2	.045	100-240	18-26
1.6	1/16	120-300	20-28
2.0	5/64	180-360	22-28
2.4	3/32	220-380	24-29
2.8	7/64	260-400	26-30

DURUM Verschleißschutz GmbH
 Carl-Friedrich-Benz-Str. 7, 47877 Willich, Deutschland
 Tel.: +49 (0) 2154 48 37 0, Fax: +49 (0) 2154 48 37 78
 www.durmat.com; info@durum.de

