

DURMAT[®] FD 200 K

Classification:

DIN EN 14700
T Fe10-200-CKNPZ

DIN 8555
MF 8-200-CKNPZ

AWS
similar 307

General Characteristics:

DURMAT[®] FD 200 K is a flux core wire of the CrNiMn-type (1.4370). The complete austenitic weld material shows high plasticity and can be applied as a buffer layer. The deposits can be work hardened, are heat resistant up to 850° C, stainless and not magnetic. DURMAT[®] FD 200 K is suitable for welding steels with more than 0.7 % C and other difficult combinations, because it deposits a most ductile weld metal. The deposits resist high shrinkage and impact stresses.

Application:

Repair of: manganese steel buckets and shovels, high tensile tools and dies, clutches, crane wheels, earthmoving undercarriage parts, gear wheels, etc.

Typical chemical composition (in wt-%):

C	Si	Mn	Cr	Ni	Fe
0.1	0.4	6	19	8.5	Balance

Physical characteristics:

Hardness: 180 - 200 HB when deposited
400 HB when hardened
Tensile strength: 580 N/mm² minimum
Elongation: 40 % minimum

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	180 - 220	20 - 26
2.0	5/64	220 - 250	22 - 26
2.4	3/32	260 - 300	24 - 27
2.8	7/64	300 - 340	27 - 28