

DURMAT[®] FD 55 Mo

Classification:

DIN EN 14700
T Fe15 (MF 10-60-G)

General Characteristics:

DURMAT[®] FD 55 Mo is a flux core wire, which deposits a high C-Cr-Mo-alloyed stainless weld metal with excellent resistance to abrasion and medium impact. It can be used whenever high abrasion accompanied by corrosion is expected. The additional alloyed 1.3 % Mo enables a higher warm strength of the deposit in comparison to DURMAT FD 55. Best results are achieved by welding in two layers. A maximum deposit thickness of 8 mm is recommended. The resulting deposits can not be heat treated, machined or forged. Before overlaying previously hardfaced surfaces a buffer layer of DURMAT[®] FD 200 K or DURMAT[®] FD 250 K is recommended.

Application:

Bucket teeth and lips, sand pumps (wet sand possible), catalyst piping, impellers and screws.

Typical chemical composition (in wt-%):

C	Si	Mn	Cr	Mo	Fe
5	1.7	0.4	27	1.2	Balance

Typical physical characteristics:

Hardness: 57 - 60 HRC

Sales units:

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

Welding recommendation:

Ø mm	Ø inch	Amps	Voltage
1.2	0,045	120 - 220	18 - 25
1.6	1/16	180 - 260	20 - 26
2.0	5/64	220 - 280	22 - 26
2.4	3/32	260 - 320	24 - 27
2.8	7/64	300 - 380	27 - 28