DURMAT® FD 64

Classification:

DIN EN 14700	DIN 8555
T Fe16-65-GZ	MF 10-65-GZ

General characteristics:

DURMAT® FD 64 is a C-Cr-B-alloyed flux core wire resistant to heavy mineral abrasion at elevated temperature. Before overlaying a previously hardfaced surface a buffer layer of DURMAT FD® 200 K or DURMAT® FD 250 K is recommended.

Application:

Cement industry, mineral and brick industry, mining industry and parts subject to heavy wear in combination with temperature.

Typical chemical composition (in wt-%):

C	Si	Mn	Cr	V	W	B	Fe
4.5	1	1.6	24	0.8	0.8	1	Balance

Physical characteristics:

Hardness:	20 °C:	63 - 65 HRC
	400° C:	60 HRC
	600° C	46 - 48 HRC

Sales units:

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

Welding recommendation:

Ø mm	Ø inch	Ampere	Volt
1.2	0.045	120 - 220	15 - 24
1.6	1/16	160 - 260	20 – 26
2.0	5/64	240 - 280	22 – 26
2.4	3/32	280 - 340	24 – 27
2.8	7/64	320 - 400	25 - 28

Please observe all appropriate safety regulations in force. The technical informations given in this data sheet reflects the present state of knowledge. They do not form part of any sales contract as guaranteed properties of the delivered materials. Our delivery and sales conditions apply to all contracts included.