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DIN EN 14700 TZ Fe 8-50-PRT

CORODUR® 476

CORODUR® 476 is a high Cr- Ni- Mo- Co- V- W- alloyed flux cored wire. It was especially developed for the hardfacing of rolls for hot rolling. The weld deposit is corrosion and wear resistant. Furthermore it is resistant to impact loads and continuous rating through heat effect and high pressure. The hardfacing should be done in 2 – 3 layers. The finished layer should be 5 mm. The interpass temperature should not exceed 450°C.

Steel mill rolls.

IMPACT RESISTANT APPLICATIONS

TYPICAL ALL WELD METAL ANALYSIS (%)

Base = Fe

C	Si	Mn	Cr	Ni	Mo	Co	V
0,3	0,3	0,8	16,0	4,0	1,5	1,5	1,0

Hardness HRc	48–50

PARAMETER

Diameter	Voltage	Amps
1,2	20–24	150–200
1,6	22–26	180–240
2	25–27	220–260
2,4	25–27	260–300
2,8	26–28	280–340

Other Dimensions on demand

FORMS OF DELIVERY

Unit	Weight
Coil BS 300	15 kg
Coil B 450	25 kg
Drums	300 kg

G = Gas shielded, OA = Open Arc, SA = Submerged Arc

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Corodur Fülldraht GmbH may change the characteristics of the wire without notice. Statements on composition and application are just for the applier's information. Statements on mechanical properties always refer to the all-weld-metal according to valid standards. We recommend the applier to check our products for their special application autonomously.