

# CORODUR® 600

C- Mn- Cr- Mo- V- alloyed flux-cored wire electrodes for abrasion and impact resistant hardfacing. The deposit is crack-free, hard, tough and heat resistant up to 500°C. An increase of hardness by annealing is possible. For base materials that are difficult to weld, a

buffer layer of 200 K or 250 K is recommended. Preheating is recommended. Applications are crusher wheels, dredger parts, pan grinders, and as the final layer for hardfacing manganese steel.



dredging parts, gravel pumps, blowbars, screws, crusher hammers, drive tumblers

## TYPICAL ALL WELD METAL ANALYSIS (%)

Base = Fe

C	Si	Mn	Cr	Mo	V	Co
0,5	1	2,2	6,5	0,6	0,2	14

Hardness HRc	55-57
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IMPACT RESISTANT APPLICATIONS

## 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