

CORODUR® 69

CORODUR 69 is a tubular wire for extreme abrasive wear, even at high temperatures up to 650°C. The deposit has a very fine ledeburitic structure, bearing a lot of different very hard carbides. CORODUR 69 is used, wherever abrasive wear is extremely high. It is also wear resistant at high temperatures up to 650 °C. Due to the high hardness pre heating of the base metal is recommended. The deposit should be

subjected to little impact stress. The deposit is nearly free of slag; the weldability is excellent. Good results are already achieved by welding one layer. A maximum deposit thickness of 6 to 8 mm (2 layers) is recommended. The resulting deposits cannot be heattreated, machined or forged. Before overlaying on old previously hard-faced surfaces a buffering layer of CORODUR 200 K or 250 K is recommended.



Concrete-industry, mixer parts, extruder, scrapers, sintering grates, mining.

TYPICAL ALL WELD METAL ANALYSIS (%)

Base = Fe

C	Si	Mn	Cr	Nb	B
5,2	0,8	0,4	32,5	5,8	1,8

Hardness HRc

64-67

PARAMETER

Diameter	Voltage	Amps
1,6	20-26	160-260
2	22-26	240-280
2,4	24-27	280-340
2,8	25-28	320-400

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