

CORODUR[®] E 250 K

CLASSIFICATION:

DIN EN 14700
E Fe9

GENERAL CHARACTERISTICS:

Basic coated, AC-weldable electrode with approx. 140 % recovery. Due to the weld metal's high tenacity and hardness, CORODUR 250 K is suitable for hardfacing on parts which are subject to extreme impact stress and cavitation. A considerable increase in wear resistance through strain hardening can be achieved by cold - hammering.

APPLICATION:

Excavator teeth, crushing hammers, rings in rotary furnaces, rail switch cores, rails, rollers, etc.

TYPICAL ALL WELD METAL ANALYSIS (%):

C	Si	Mn	Cr	Ni	Mo	V
0,5	0,4	16,0	14,0	0,8	0,5	0,2

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

Hardness: 220 – 250 HB
Work hardened: app. 500 HB

CURRENT:

= + / ~ 65 V

WELDING POSITIONS:

PA, PB, PC, PD, PE

REBAKING:

1 h, 350 °C + / - 10 °C (if required)