

CORODUR[®] E 68 T

CLASSIFICATION:

DIN EN 14700 E Fe14

GENERAL CHARACTERISTICS:

Thickly coated high efficiency electrode with approx. 210 % recovery. The weld metal structure is ledeburitic, the alloy contains carbide forming elements of different kinds.

CORODUR E 68 T is mainly used for applications where parts are subject to strong abrasive wear since the deposited alloy is highly resistant to abrasion, also when exposed to high temperatures. Smooth fusion, almost slag-free deposit. Prior to surfacing on old hardfacing layers a buffer layer with CORODUR 200 K is recommended.

APPLICATION:

CORODUR E 68 T is mainly used for hardfacing on equipment in sintering plants, steel mills, coke oven plants, coal excavation and overburden removal, etc.

TYPICAL ALL WELD METAL ANALYSIS (%):

С	Si	Cr	Others
4,0	2,0	28,0	4,0

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

Hardness: 68 - 70 HRc

CURRENT:

 $= + / \sim 50 \text{ V}$

WELDING POSITIONS: PA, PB

REBAKING:

1 h, 150 °C + / - 10 °C (if required)

Rev. 03-2010:1