CORDIFF 50 OA

Characteristics:

CORDIFF 50 OA is a tubular wire, which deposits give C-Si-Mn-Cr weld metal having good abrasion resistance under moderately high impact. Multipass deposit is possible.

Applications:

Buildup of crusher parts, bucket teeth and lips, trash crushing etc. with applications were abrasive wear in combination with medium impact.

Standard:  DIN 8555 - MF-10-GF-50-G

Hardness:  50 - 55 HRC

Major Alloying element:

<table>
<thead>
<tr>
<th></th>
<th>C</th>
<th>Si</th>
<th>Mn</th>
<th>Cr</th>
</tr>
</thead>
</table>

WELDING PARAMETERS:  Current – DC+

<table>
<thead>
<tr>
<th>DIA. (mm)</th>
<th>VOLTAGE</th>
<th>AMPS</th>
</tr>
</thead>
<tbody>
<tr>
<td>1.6</td>
<td>22 – 26</td>
<td>170 – 230</td>
</tr>
<tr>
<td>2.0</td>
<td>24 – 27</td>
<td>220 – 260</td>
</tr>
<tr>
<td>2.4</td>
<td>25 – 29</td>
<td>260 – 330</td>
</tr>
<tr>
<td>2.8</td>
<td>27 – 30</td>
<td>300 – 360</td>
</tr>
</tbody>
</table>

STANDARD PACKING:

Spool = 15 kgs (± 1kg)  Spool = 25 kgs (± 1kg)  Drum = 200 – 250 kgs