

CORODUR 324

Corodur 324 is specially developed flux cored wire with high alloying content, which produces bright and smooth bead. Chemistry is so controlled; the ferrite-austenite duplex structure provides resilience with very high strength.

Applications:

High strength, crack resistant joining of unknown and dissimilar steels, Hadfield High Carbon and alloy steels. Also recommended for tough and wear resistant overlays on all steels.

Major Alloying Elements:

Mn	Cr	Mo	Ni
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Mechanical Properties Of Weld Metals:

Tensile strength N/mm	Elongation %
700-850	20 % min.

Welding Parameters:

DIA. (mm)	VOLTAGE	AMPS
1.6	24 – 26	180 – 220
2.0	25 – 28	220 – 250
2.4	26 – 28	260 – 300
2.8	27 – 30	300 - 340

Standard Packing:

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

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