

## CORODUR 200 K

CORODUR 200 K is a tubular wire of the Cr-Ni-Mn- type. The fully austenitic weld material has high plasticity and acts as a plastic buffer. Deposits are work hardening, thermal shock resistant upto 850<sup>0</sup>C, stainless and not magnetic. CORODUR 200 K is suitable for welding steels with more than 0.7%C and other difficult combinations, because it deposits a most ductile weld metal. The deposits resist high shrinkage stresses and impact loading.

### Welding Recommendations:

Depending on high elongation the alloy is suitable for ductile buffer layer on old hardfacing and joining dissimilar weldable steels.

### Applications:

Repair of manganese steel buckets and shovels, high tensile tools and dies, clutches, crane wheels, earthmoving undercarriage parts, gear wheels, buffer layers etc.

### Standard:

**DIN 8555 – MF8-GF-200-CKNPZ**

### Hardness:

<b>As Deposited</b>	150 – 220 BHN
<b>Work Hardened</b>	400 BHN

### Mechanical Properties Of Weld Metals :

Tensile strength N/mm	Yield strength N/mm	Elongation %
600	>420	>30

### Welding Parameters: Current – DC+

DIA. (mm)	VOLTAGE	AMPS
1.6	20 – 25	170 – 240
2.0	23 – 27	220 – 260
2.4	24 – 29	260 – 330
2.8	26 – 30	300 - 370

### Standard Packing :

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

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