

CORODUR 55-MO

A tubular wire CORODUR 55 Mo which deposits a high C-Cr-Mo alloyed stainless weld metal with excellent resistance to abrasion and medium impact. The weld deposit has a higher temperature resistance upto 450°C. Where high abrasion accompanied by corrosion is expected - it can be used. The additional alloyed 1.3 % Mo gives the deposit a high warm strength.

Welding Recommendations-

Best results are achieved by welding in two layers. The resulting deposits cannot be heat treated, machined or forged. Before overlaying on old previously hardfaced surfaces a buttering layer of CORODUR 200 K or CORODUR 250 K is recommended.

Applications-

Bucket teeth and lips, sand pumps (wet sand possible), mixture parts, impellers and conveyer screws

Standard-

DIN 8555 - MF- 10- 55- GR

Hardness

57 - 60 HRC

Major Alloying element-

C	Si	Cr	Mo	Fe
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Welding Parameters- Current – DC+

DIA. (mm)	VOLTAGE	AMPS
1.6	22 – 26	170 – 230
2.0	24 – 27	220 – 260
2.4	25 – 29	260 – 330
2.8	27 – 30	300 - 360

Standard Packing-

Spool = 15 kgs(± 1kg) Spool = 25 kgs(± 1kg)

Drum = 200 - 250kgs

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