

## CORODUR 61 OA

CORODUR 61-OA flux cored wire, alloyed C-Cr-Nb & B gives weld deposit of extremely hard special carbides in higher hardness. It is used for hardfacing and the weld metal has excellent abrasion resistance because it offers an excellent resistance against abrasion.

### Welding Recommendations:

Best results are achieved by welding in two layers. A maximum deposit thickness of 8 mm is recommended. The resulting deposits cannot be heat treated, machined or forged. Before overlaying on old previously hard faced surfaces a buffer layer of CORODUR 200K OR CORODUR 250 K is recommended.

### Applications:

Bucket teeth & lips, fan blades, hard facings on parts for coal mining equipment, cement and mineral industries.

### Standard:

**DIN 8555 – MF 6 – GF – 60 PG**

### Hardness:

**63 - 65 HRC**

### Technical Data:

<b>C</b>	<b>Si</b>	<b>Cr</b>	<b>Nb</b>	<b>B</b>
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### Welding Parameters:

DIA. (mm)	VOLTAGE	AMPS
1.6	22 – 26	180 – 240
2.0	23 – 28	220 – 260
2.4	25 – 30	260 – 320
2.8	26 – 31	300 - 360

### Standard Packing :

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

**Drum = 200 - 250kgs**

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