

CORDIFF 200K

Characteristics:

CORDIFF 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 850⁰C, stainless and not magnetic.

CORDIFF 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:

As Deposited	150 – 220 BHN
Work Hardened	400 BHN

Mechanical properties of weld metals:

Tensile strength N/mm ²	Yield strength N/mm ²	Elongation %	Impact Energy J
600	>420	>30	>31

Major Alloying Element:

C	Si	Mn	Cr	Ni
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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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