

CORDIFF 250K

Characteristics:

CORDIFF 250K is a tubular wire of the Cr-Mn- type which is fully austenitic weld material has high plasticity and acts as a plastic buffer. Deposits are stainless, not magnetic and hardness after work hardening approximately up to 500 BHN. It deposits a most tough and ductile weld metal, so it is preferable for welding buffer layers before welding over old hardfacing. The deposits resist high shrinkage stresses and impact loading.

Applications:

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

Standard: DIN 8555 – MF7-GF-250-KNP

Hardness:

As Deposited	200-240 HB
Work Hardened	480 HB

Major Alloying Element:

C	Si	Mn	Cr	Ni	Mo	V
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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	250 – 330
2.8	26 – 30	310 - 370

STANDARD PACKING:

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

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