

CORODUR 356

Characteristics:

CORDIFF 356 is a Cr, Ni, and Mo alloyed tubular wire. The welding deposit is highly suitable for welding on tough, corrosion resistant continuous – cast rolls and also wears parts from the steel industry and large machinery. Apart from corrosion resistance, it also has a further capability in protecting against cavitation, erosion and also capable of resisting pitting.

Standard:

DIN 8555 TFe7 MF5-40-CPT

Applications:

Exclusively developed for applications like continuous casting rolls, Bridge store, depositions to thick areas of water, steam and gas fittings for operating temperatures to 450⁰ C; rope pouring roles; on alloying buffer layers.

Welding Recommendations:

Preheating and heat treatments as necessary for ferritic Cr-steels are not necessary.

Major Alloying element:

C	Cr	Mo	Ni	Nb	V
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Hardness: 40 – 42 HRC.

WELDING PARAMETERS: Current: DC+

DIA. (mm)	VOLTAGE	AMPS
1.6	20 – 26	160 – 240
2.0	22 – 27	220 – 260
2.4	24 – 28	260 – 340
2.8	25 – 30	300 - 370

STANDARD PACKING:

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

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