

## CORDIFF 4015

### Characteristics:

CORDIFF 4015 is a Flux Cored Wire which provides tough and corrosion resistant overlay against wear from sea water and power plant operation. The weld metal is high Cr alloy stainless steel. Avoid high heat input during welding, for better results always used low heat input.

The alloy is highly suitable for sealing surfaces on water–steam and gas-valves for working temperatures up to 450<sup>0</sup>C. The weld deposit has excellent resistance to corrosion, pitting and impacts loads. It is also suitable for base layer welding on tough, corrosion resistant continuous cast rolls.

### Applications:

Deposition of continuous casting rolls, Bridge store; deposition to thick areas of water, steam and gas fittings for operating temperatures to 450 °C; rope pouring roles; on alloying buffer layers.

Standard: DIN 8555 - MF5- GF-200-PRZ

### Hardness:

220 - 240 BHN

### Major Alloying Element:

C	Si	Mn	Cr
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### WELDING PARAMETERS: Current – DC+

DIA. (mm)	VOLTAGE	AMPS
1.6	20 – 26	160 – 240
2.0	22 – 27	200 – 270
2.4	24 – 28	260 – 320
2.8	25 – 29	300 – 360
3.2	26 – 30	320 – 400

### STANDARD PACKING:

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

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