

CORDIFF 450

Characteristics:

Cordiff 450 OA is a hardfacing wire, which produces a deposit for hardfacing of approximately 450 BHN to give superior resistance to high pressure, abrasion and impact. Deposits are crack free and machinable. This electrode can be used for multiplayer welding. The weld metal has the heat resistance upto 500° C with Bainitic plus Martensitic structure. For base metals with high carbon content, preheating is recommended.

Applications:

Rollers, wheel rims, bucket chains, dragline shovel buckets, shafts, sprockets, crushers etc. of earth moving machinery parts.

Standard:

DIN 8555 MF-5-45-PT

Hardness:

42 – 45 HRC

Major Alloying elements :

C	Si	Mn	Cr	Mo
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Welding Parameters: Current : DC+

DIA. (mm)	VOLTAGE	AMPS
1.6	20 – 24	160 – 230
2.0	23 – 26	220 – 260
2.4	24 – 27	280 – 330
2.8	25 – 28	300 - 360

Standard packing:

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

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