

CORDIFF 55MO

Characteristics:

A tubular wire CORDIFF 55 Mo which deposits a high C-Cr-Mo alloyed stainless weld metal with excellent resistance to abrasion and medium impact. The weld deposit has a higher temperature resistance upto 450⁰C. Where high abrasion accompanied by corrosion is expected - it can be used. The additional alloyed 1.3 % Mo gives the deposit a high warm strength.

Welding recommendations:

Best results are achieved by welding in two layers. The resulting deposits cannot be heat treated, machined or forged. Before overlaying on old previously hardfaced surfaces a buttering layer of CORDIFF 200 K or CORDIFF 250 K is recommended.

Applications:

Bucket teeth and lips, sand pumps (wet sand possible), mixture parts, impellers and conveyer screws etc.

Standard: **DIN 8555 - MF- 10- 60- G**

Hardness: **57 - 60 HRC**

Major Alloying element:

C	Si	Cr	Mo
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WELDING PARAMETERS: Current – DC+

DIA. (mm)	VOLTAGE	AMPS
1.6	22 – 26	170 – 230
2.0	24 – 27	220 – 260
2.4	25 – 29	260 – 330
2.8	27 – 30	300 - 360

STANDARD PACKING:

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

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