

DURMAT[®] FD 56

Classification:

DIN EN 14700
T Fe15 (MF 10-60-GR)

General characteristics:

DURMAT[®] FD 56 is a high C-Cr-alloyed self shielding flux core wire. The alloy is especially made for overlaying parts which are exposed to very extreme abrasive mineral wear related to the high amount of hard phasing, hypereutectic M₇C₃-carbides. The overlay is also corrosion-resisting. DURMAT[®] FD 56 should be applied for a maximum of 2 or 3 layers, with a maximum of 10 mm height. For best results only 2 layers should be applied and the hardfaced area should not be exposed to pounding or impact load. Before overlaying previously hardfaced surfaces a buffer layer of DURMAT[®] FD 250 K is recommended.

Application:

Wear plates, spiked rollers, cement and concrete pumps, slag breakers, coke oven slides and Ni-Hard IV.

Chemical composition (in wt-%):

C	Si	Mn	Cr	Fe
5,4	1	0.4	32	Balance

Physical characteristics:

Hardness: 58 – 60 HRC

Sales units:

Coil "S" 15 kg
Coil "B" 25 kg
Drum 250 kg

Welding recommendation:

Ø mm	Ø inch	Amps	Voltage
1.6	1/16	180 - 220	20 - 26
2.0	5/64	220 – 250	22 – 26
2.4	3/32	260 – 300	24 – 27
2.8	7/64	300 – 340	27 - 28