

DURMAT[®] FD 68

Classification:

DIN EN 14700
T Fe15 (MF 10-70-CGZ)

General Characteristics:

DURMAT[®] FD 68 is a flux core wire for hardfacing and is resistant to extreme abrasive wear even at elevated temperatures. The deposit has a ledeburitic structure containing a high amount of different hard phases.

DURMAT[®] FD 68 is used where ever abrasive wear is extremely high even at elevated temperatures up to 800°C. The deposit is free of slag, the weldability is excellent. Best results are achieved by welding two layers. A maximum deposit thickness of 8 mm is recommended. The resulting deposits can not be heat treated, machined or forged. Before overlaying previously hardfaced surfaces a buffer layer of DURMAT[®]FD 200 K or DURMAT[®]FD 250 K is recommended.

Application:

Blast furnace bells, coke oven screens and doors, sinter wheel breakers, smelter loading chutes, etc.

Chemical composition (in wt-%):

C	Si	Mn	Cr	B	Fe
5	0.8	0.4	38	2	Balance

Physical characteristics:

Hardness:	20 °C:	66 - 68 HRC
	600 °C:	63 - 64 HRC
	800 °C:	58 HRC

Sales units:

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

Welding recommendation:

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