

DUR 21

CATEGORY	FCAW Flux-Cored						
TYPE	Cobalt based fluxcored wire for cladding against metal to metal wear, thermal shock and erosion.						
APPLICATIONS	Solving wear problems against chemicals, erosion, corrosion, high temperatures, abrasion and combinations of those.						
PROPERTIES	Excellent gliding properties against metal to metal wear due to low friction, Excellent against erosion and corrosion at high working temperatures upto 900°C. Crack free hard facing deposit against severe shock and impact.						
CLASSIFICATION	AWS	A 5.21: ERC CoCr-E					
	EN ISO	14700: E Co1					
	DIN	8555: MF 20-GF-300-CTZ					
SUITABLE FOR	Cladding seats and valves in chemical industry, hot shearing blades, extrusion parts, coke hammers, turbine injectors, gas and steam turbine parts.						
APPROVALS	CE approved						
WELDING POSITIONS:							
FILLER METAL ANALYSIS % (TYPICAL VALUES)							
C	Mn	Si	Cr	Ni	Mo	Fe	Co
0.27	1.0	1.25	28	1.5-4.0	5.0	3.5	Bal.
MECHANICAL PROPERTIES							
Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness HRc / HB
				-20°C	-40°C	-60°C	
as welded							33 HRc
at 600°C							240 HB
strain hardening							42-45 HRc
WELDING PARAMETERS / PACKING							
Welding Parameters			Packing				
D (mm)	Voltage (V)	Current (A)	spool type	kg / spool	kg / pallet		
1.2	20-31	110-180	S-300	15			
1.6	20-31	150-250	S-300	15			
2.4	20-31	300-400	S-300 / K-415	15 / 25			
REDRYING TEMPERATURE	150°C / 24 hr						
GAS ACC. EN ISO 14175	M13 (99%Ar - 1%O ₂)						