

CORODUR[®] E 405 T

CLASSIFICATION:

DIN EN 14700
E Z Fe15

GENERAL CHARACTERISTICS:

Tubular electrode filled with chromium carbide powder, suitable for hardfacing on parts which are mainly subject to abrasive wear, but also to impact stress. High amount of Cr- carbides in an austenitic matrix, very compact. Due to its special metallurgical composition, this electrode can be consumed with very low current. High hardness is achieved already in the first layer.

Soft, quiet fusion. The weld metal is almost free of slag.

A buffer layer of CORODUR 200 K is recommended prior to surfacing on old claddings.

APPLICATION:

Mainly used for hardfacing on pump bodies, mixer blades, agitator arms, concrete pumps, conveyer worms, and coke-oven slides, and agricultural machines, in civil engineering and in the cement industry.

TYPICAL ALL WELD METAL ANALYSIS (%):

C	Mn	Cr	Others
5,5	1,5	40,0	2,0

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

Hardness: 62 - 64 HRc

CURRENT:

= + / ~ 50 V

WELDING POSITIONS:

PA, PB

REBAKING:

1 h, 150°C + / - 10 °C (if required)