

CORODUR® 609

High Cr-alloyed flux-cored wire electrode for welding wear resistant layers with a ferritic - martensitic micro structure. The welding deposit is high resistant to impact stress and

medium abrasion. The deposit is in spite of the high hardness crack free also in multiple layers and can be used up to 700°C. Hot hardness 45 HRc at 450°C.



Crusher wheels and hammers, rock processing, shredders, cutting- tools, and fluid-valves and protection welding on Mn - hadfield - steel.

TYPICAL ALL WELD METAL ANALYSIS (%)

Base = Fe

C	Si	Mn	Cr	Ni
0,5	2,8	1,2	9,5	0,3

Hardness HRc	55-57
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IMPACT RESISTANT APPLICATIONS

PARAMETER

Diameter	Voltage	Amps
1,2	20-24	150-200
1,6	22-26	180-240
2	25-27	220-260
2,4	25-27	260-300
2,8	26-28	280-340

Other Dimensions on demand

FORMS OF DELIVERY

Unit	Weight
Coil BS 300	15 kg
Coil B 450	25 kg
Drums	300 kg

G = Gas shielded, OA = Open Arc, SA = Submerged Arc