

CORODUR® 250 K

CORODUR® 250 K is a highly Mn- Cr- alloyed flux-cored wire. The fully austenitic weld material has high plasticity and acts as a plastic buffer. Deposits have a work hardening up to 500 HB, are stainless and not magnetic.

CORODUR® 250 K is suitable for welding buffer layers before welding over old hardfacings, because it deposits a ductile weld metal. The deposit resists high shrinkage stresses and impact loadings.



Repair of: Manganese steel buckets and shovels, high tensile tools , mill-shafts , clutches, crane.

TYPICAL ALL WELD METAL ANALYSIS (%)

Base = Fe

C	Si	Mn	Cr	Ni	Mo	V
0,5	0,4	16,0	14,0	0,8	0,5	0,2

Hardness HB

220 – 250

up to 500
work hardened

WORK HARDENING AUST. HARDFACING

PARAMETER

Diameter	Voltage	Amps
1,2	18-24	140-240
1,6	20-26	160-260
2,0	22-27	220-280
2,4	24-28	280-340
2,8	25-29	320-400

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