

CORODUR® 868

CORODUR® 868 is a flux cored wire, which produces a heat and thermal shock resistant deposit. The wire is designed for maintenance of hot working tools and to increase their service life. The number of layers can be done as necessary.

The interpass temperature should be maximum 250°C. The alloyed weld deposit with excellent properties of resistance to impact. CORODUR® 868 is only machinable by flat engraving.



TYPICAL ALL WELD METAL ANALYSIS (%)

Basis = Fe

C	Si	Mn	Cr	Mo	V	W	Ti
0,40	0,8	0,6	6,0	3,0	0,7	3,0	0,2

Hardness HRc 52 - 55,5

Tensile strength N/mm² 1800-2000**

** flat engraving

HOT FORGING MOLDS

PARAMETER

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

Other dimensions on request

FORMS OF DELIVERY

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

G = Gas shielded