

# CORODUR® WZ 50

Suitable for repair and build-up applications on hot working steels of similar or lower alloyed hot working tools is the CORODUR® WZ 50 is a C-Cr-V-W- alloyed flux cored wire electrode.

The weld deposit is machinable, heat treatment is possible and has a retention of hardness up to 550 °C.



Forging dies, hot shear blades, mandrels.

## TYPICAL ALL WELD METAL ANALYSIS (%)

Base = Fe

C	Si	Mn	Cr	V	W
0,3	0,6	0,4	3,0	0,6	4,5

Hardness HRC	48-50	50-52
	As welded; air cooled	Heat treated 2h at 530 °C. Furnace cooling

TOOL STEEL ALLOYS

## PARAMETER

Diameter	Voltage	Amps
1,2	18-24	140-240
1,6	20-27	160-270
2,0	25-28	220-280
2,4	26-30	260-340
2,8	28-30	320-400
3,2	28-31	360-450

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, OA = Open Arc, SA = Submerged Arc