

# CORODUR® 814

CORODUR® 814 is a Cr- Mo- Ni- alloyed weld deposit with excellent properties of resistance to impact at higher temperature. The wire is designed for maintenance of hot working tools

and to increase their service life. For dies subjected to high heat and stress when a machinable deposit is required.



## TYPICAL ALL WELD METAL ANALYSIS (%)

Basis = Fe

C	Si	Mn	Cr	Ni	Mo	Ti
0,20	0,6	0,6	10,0	1,7	3,0	0,2

Hardness HRC 44-48,5

Tensile strength N/mm<sup>2</sup> 1400-1600\*

\* machinable

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