

CORODUR® 866

CORODUR® 866 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 ser-

vice life. The number of layers can be done as necessary. The interpass temperature should be maximum 250°C. The alloyed weld deposit has excellent properties of resistance to impact.



TYPICAL ALL WELD METAL ANALYSIS (%)

Basis = Fe

C	Si	Mn	Cr	Mo	V	W	Ti
0,30	0,7	0,6	5,5	2,5	0,6	2,4	0,2

Hardness HRc 48,5 - 52

Tensile strength N/mm² 1600-1800

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