

CORDIFF 600 OA

Characteristics:

CORDIFF 600 OA is a tubular wire which produces a Cr-Mo-V alloyed deposit. The weld metal has high hardenability and produces hardness up to 56 Rc even with relatively slow cooling rates. Crack resistance is good provided adequate preheat and interpass temperature are applied together with slow cooling after welding. Resistance to tempering is good.

Applications:

Best choice for intermediate hardfacing layer for Roller Press Rolls. Parts subjected to abrasion, impact and compressive loads, crusher wheels, crusher hammers, pan grinders, sand pumps, dredge pump parts, gravel pumps, dredge ladder rolls, screws, blowbars and drive tumblers etc.

Standard: **DIN 8555 – MF 6 - 60 - RP**

Hardness:

53 - 56 HRC

Major Alloying element:

C	Mn	Cr	Mo	V
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WELDING PARAMETERS:

DIA. (mm)	VOLTAGE	AMPS
1.6	24 – 26	180 – 220
2.0	25 – 27	220 – 250
2.4	25 – 28	260 – 320
2.8	27 – 30	300 - 350

STANDARD PACKING:

Spool = 15 kgs (± 1kg) Spool = 25 kgs(± 1kg) Drum = 200 - 250kgs

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