

DUR 21

CATEGORY FCAW Flux-Cored

TYPE Cobalt based fluxcored wire for cladding against metal to metal wear, thermal shock and erosion.

APPLICATIONS Solving wear problems against chemicals, erosion, corrosion, high temperatures, abrasion and combinations of those.

PROPERTIES Excellent gliding properties against metal to metal wear due to low friction, Excellent against erosion and corrosion at high working temperatures upto 900°C. Crack free hard facing deposit against severe shock and impact.

CLASSIFICATION

AWS	A 5.21: ERC CoCr-C
EN ISO	14700: T Co1
DIN	8555: MF 20-GF-300-CTZ

SUITABLE FOR Cladding seats and valves in chemical industry, hot sharing blades, extrusion parts, coke hammers, turbine injectors, gas and steam turbine parts.

APPROVALS CE approved

WELDING POSITIONS:



FILLER METAL ANALYSIS % (TYPICAL VALUES)

C	Mn	Si	Cr	Ni	Mo	Fe	Co
0.27	1.0	1.25	28	1.5-4.0	5.0	3.5	Bal.

MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness HRc / HB
				-20°C	-40°C	-60°C	
As welded							30 HRc
At 300°C							280 HB
Work hardened							45 HRc

WELDING PARAMETERS / PACKING

D (mm)	Welding Parameters		Packing	
	Voltage (V)	Current (A)	spool type	kg / spool
1.2	19-22	120-220	S-300	15
1.6	20-26	160-260	S-300	15
2.4	24-28	260-340	S-300 / K-415	15 / 25

REDRYING TEMPERATURE 150°C / 24 hr

GAS ACC. EN ISO 14175 M13 (99%Ar - 1%O₂)