

Dur WC 3000

TYPE Crushed Tungsten / Cobalt particles for the MAG carbide feeder system.

APPLICATIONS Dur WC 3000 is used in combination with the MAG proces to develop a sharp and rough surface on cutting tools for steel and or concrete sawing and or crushing applications. These particles can be used in combination with medium hard, extra hard and corrosion resistant filler metals that fits the application.

PROPERTIES The particles should fall before the solidification in the molten weldpool and become part of the weld deposit, Metal core fluxcored wires are recommended in spray arc to obtain the best results. The torch angle should be in trailing position at about 80 degrees towards the work piece.



CLASSIFICATION AWS no standard
EN ISO no standard

SUITABLE FOR concrete drilling, earth moving tools, recycling bars and hammers, cutting applications, sawing steel and concrete, deepsea wrack sawing, mixing paddles, scraper blades, mining etc....

WELDING POSITIONS:



PARTICLE COMPOSITION (SINTERED)

C	Co	W	Ta	Ti	Fe
5.5	6-10	Rem	<0.5	<0.5	<0.5

MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V -20°C -40°C	specific mass g/cm ³	Hardness HV
as sintered					14.2-14.8	2800-3200

TO BE USED WITH METAL CORE FCAW WIRE

particle sizes (mm)	wire diameter (mm)	Welding Parameters		Packing kg
		Current (A)	Voltage (V)	
0.2-0.5	1,0	120-230	16-29	5 / 25
0.5-1.0	1.2	140-300	16-32	5 / 25
1.0-2.0	1.4	200-360	16-33	5 / 25
2.0-4.0	1.6	200-420	17-34	5 / 25
4.0-8.0	2.4	280-575	20-36	5 / 25
8.0-12.0	2.4	280-575	20-36	5 / 25

REDRYING TEMPERATURE not required