

CARBODUR 65

Standards DIN 8555 E 10-UM-65-GRZ

AWS A5.13/21 EFeCr-A1

Approvals

Characteristics CARBODUR 65 is a heavy coated high efficiency hardfacing electrode

with 240 % recovery.

The weld metal has a ledeburitic structure with an alloy containing car-

bides of different kinds.

The electrode is used for hardfacing of parts subject to strong abrasive wear, friction also at high temperatures. The weld metal structure is ledeburitic, the alloy contains carbide forming elements of different kinds.

CARBODUR 65 provides extremely high resistance to abrasion also at

temperatures up to 600°C.

The weld metal is nearly free of slag.

A buffer layer of CARBO 4370 MPR is recommended prior to surfacing on

old claddings.

Typical applications CARBODUR 65 is mainly used for hardfacing on conveyor worms, clinker

crushers, blast furnace bells, grates in mineral dressing equipment, es-

pecially where live coal and slag are treated

Operating temperature From room temperature up to + 600° C

Hardness of all-weld metal (typical values)

HRc	HRc at 400°C		
ca. 64	ca. 45		

Weld metal analysis

(typical, wt. %)

С	Si	Cr	Мо	Nb	W	V
4,5	1,2	24	6	6,2	2	1

Current $= + / \sim 50 \text{ V}$

Welding positions PA, PB

Rebaking 1 h, 150°C + / - 10 °C (if required)

Flux-cored wire equivalent

CARBO F-65

Dia./Length	Amperage (A)	Pcs./ packet	Pcs./ carton	kg / 1000	kg / packet	kg / carton
2,5 x 350	80 - 110	126	504	39,7	5.0	20.0
3,2 x 350	120 - 140	75	298	67,1	5.0	20.0
4,0 x 450	140 - 180	46	184	130,7	6.0	24.0
5,0 x 450	180 - 230	29	117	204,3	6.0	24.0

Rev. 000

Statements on composition and application are just for the applier's information. Statements on mechanical properties always refer to the all-weld-metal according to valid standards. Carbo-Weld may change the characteristics of its products without notice. We recommend the applier to check our products for their special application autonomously.