

Standards

DIN 8555	E 10-UM-65-GTZ
----------	----------------

Approvals ---

Characteristics CARBODUR 67 is a heavy coated high efficiency hardfacing electrode with 170 % recovery.
The weld metal has a ledeburitic structure with an alloy containing carbides of different kinds.
The alloy is highly resistant to abrasion combined with impact stress.
The special chemical composition of the alloy ensures good wear resistance in various temperature ranges.
The fine-grained structure of the weld metal provides a solid matrix which retains the vanadium carbides also when subject to strong abrasion and ensures high crack-resistance.
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 Hardfacing on conveyor worms, clinker crushers, grates in mineral dressing equipment, concrete and cement pumps, etc

Operating temperature ---

Hardness of all-weld metal (typical values)

HRc
ca. 65

Weld metal analysis (typical, wt. %)

C	Si	Cr	V
5	1,5	23	10

Current = + / ~ 50 V

Welding positions PA, PB

Rebaking 1 h, 130°C + / - 10 °C (if required)

Flux-cored wire equivalent

CARBO F- 67

Dia./Length	Amperage (A)	Pcs./ packet	Pcs./ carton	kg / 1000	kg / packet	kg / carton
2.5 x 350	70 – 110	152	608	32.9	5.0	20.0
3.2 x 450	110 – 140	84	335	71.6	6.0	24.0
4.0 x 450	140 – 180	55	221	108.4	6.0	24.0
5.0 x 450	180 – 230	35	142	169.4	6.0	24.0

Rev. 000