



DURMAT®-A

CLASSIFICATION: Welding Rod DIN 8555 — G21-GF-55-CG

GENERAL CHARACTERISTICS: DURMAT-A is composed of a special pre-alloyed tube filled with coarsely grained Fused Tungsten Carbide (FTC). The FTC has an exceptionally high hardness of over 2360 HV_{0,4} giving extended wear protection to hardfaced areas. For special hardfacing on machine parts of unalloyed, low alloyed or cast steel with a carbon content up to 0,45%.

A higher carbon content could lead to cracking. Depending on the size and composition of the area to be hardfaced, the proper rod diameter and grain size should be chosen. If the area will encounter heavy abrasion a small grain size is recommended. If a cutting action is desired a larger grain size is preferable.

APPLICATIONS: For hardfacing and repairing tools and machine parts exposed to wear in: Mining, Road Construction, Ceramic, Petroleum, Excavation and Dredging.

RECOMMEND

WELDING DIRECTIONS: The area to be hardfaced should be free of rust, scale, grease or other dirt. The burner nozzle should be held at a shallow angle to the work area with a neutral to slightly acetylene excess flame. To avoid overheating, the work area should be slightly wetted and the tube metal should not come into contact with the centre of the flame. Depending on the base metal and the size of the work area a preheating temperature between 350 – 500°C (660-930°F) is advised.

Detailed welding directions are available upon request.

STANDARD DIAMETERS AND MESH SIZES AVAILABLE:					
Type	Ø mm	Ø inch	grain size mm	US Mesh size	Colour code
3505	3,5	1/8	0,25 - 0,70	24-60	white
3510	3,5	1/8	0,70 - 1,20	14-24	yellow
4005	4,0	5/32	0,25 - 0,70	24-60	white
4010	4,0	5/32	0,70 - 1,20	14-24	yellow
4015	4,0	5/32	1,00 - 1,60	10-16	red
5005	5,0	3/16	0,25 - 0,70	24-60	white
5010	5,0	3/16	0,70 - 1,20	14-24	yellow
5020	5,0	3/16	1,00 - 2,00	9-16	green

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STANDARD DIAMETERS AND MESH SIZES AVAILABLE:

Type	Ø mm	Ø inch	grain size mm	US Mesh size	Colour code
6005	6,0	1/4	0,25 - 0,70	24-60	white
6010	6,0	1/4	0,70 - 1,20	14-24	yellow
6020	6,0	1/4	1,00 - 2,00	9-16	green
8010	8,0	5/16	0,70 - 1,20	14-24	yellow
8020	8,0	5/16	1,00 - 2,00	9-16	green
8030	8,0	5/16	1,50 - 3,00	7-12	blue

Standard rod lengths: 350mm (14") and 700mm (28")

Other rod lengths and mesh sizes are available on request.