



DURMAT FD 200 K

CLASSIFICATIONS:

DIN EN 14700
MF 8-200-CKNPZ

AWS
similar 307

Standard-No.
1.4370

GENERAL CHARACTERISTICS:

DURMAT FD 200 K is a flux core wire of the Cr-Ni-Mn type. The complete austenitic weld material shows high plasticity and can be applied as a buffer layer. The deposits can be work hardened, are heat resistant up to 850°C, stainless and not magnetic. DURMAT FD 200 K is suitable for welding steels with more than 0.7% C and other difficult combinations, because it deposits a most ductile weld metal. The deposits resist high shrinkage and impact stresses.

APPLICATION:

Repair of: manganese steel buckets and shovels, high tensile tools and dies, clutches, crane wheels, earthmoving undercarriage parts, gear wheels, etc.

CHEMICAL COMPOSITION (in wt-%):

C	Si	Mn	Cr	Ni	Fe
0.10	0.5	6	19	8.5	Balance

PHYSICAL CHARACTERISTICS:

Hardness: 180 HB when deposited
450 – 500 HB when hardened
Tensile strength: 850 N/mm² minimum
Elongation: 40% minimum

SALES UNITS:

Coil "S" 15kg
Coil "B" 25kg
Drum 250kg

WELDING RECOMMENDATIONS:

mm	inch	Amps	Voltage
1.6	1/16	180 - 220	20 - 26
2.0	5/64	220 - 250	22 - 26
2.4	3/32	260 - 300	25 - 27
2.8	7/64	300 - 340	27 - 28