



DURMAT FD 601

CLASSIFICATION:

DIN EN 1470
MF 6-60-PT

GENERAL CHARACTERISTICS:

DURMAT FD 601 is a flux core wire which enables a CrMoWV alloyed deposit for semi automatic and automatic surfacing. The weld metal enables hardness up to 60 HRc even with relatively slow cooling rates. Crack resistance is good in case of adequate preheat and interpass temperature together with slow cooling after welding. Resistance to tempering is good.

DURMAT FD 601 is best suited for parts subjected to abrasion, impact and compressive loads, sand pumps, dredge pump parts, dredge ladder rolls, tool - joints , etc.

APPLICATION:

Parts subjected to abrasion, impact and compressive loads, sand pumps, dredge pump parts, dredge ladder rolls, tool – joints, etc.

CHEMICAL COMPOSITION (in wt-%):

C	Si	Mn	Cr	Mo	V	W	Fe
0.50	1	3	6	1.6	1.5	1	Balance

HARDNESS:

56 - 60 HRc (700 HV)

SALES UNITS:

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

WELDING RECOMMENDATION:

mm	inch	Amps	Voltage
1.2	0.045	120 – 220	18 – 25
1.6	1/16	180 – 220	20 – 26
2.0	5/64	220 – 250	22 – 26
2.4	3/32	260 – 300	24 – 27
2.8	7/64	300 – 340	27 – 28